

# WOODNEWS

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Venjakob CEO,  
**Christian Nuesser**  
makes 'smart'  
move into India

## INSIDE

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Office Furniture  
and Tooling

Understanding  
durability of  
wood adhesives

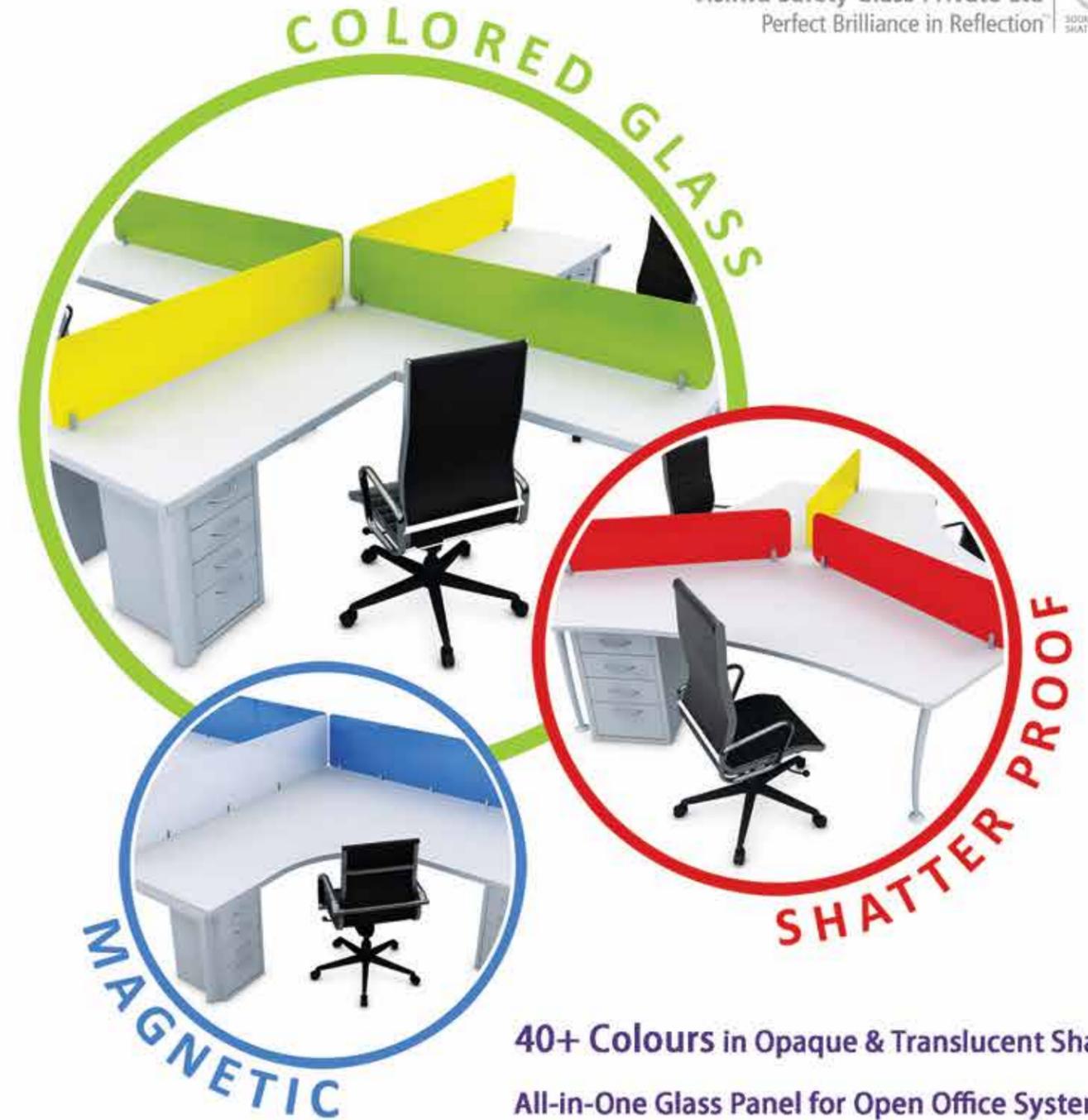
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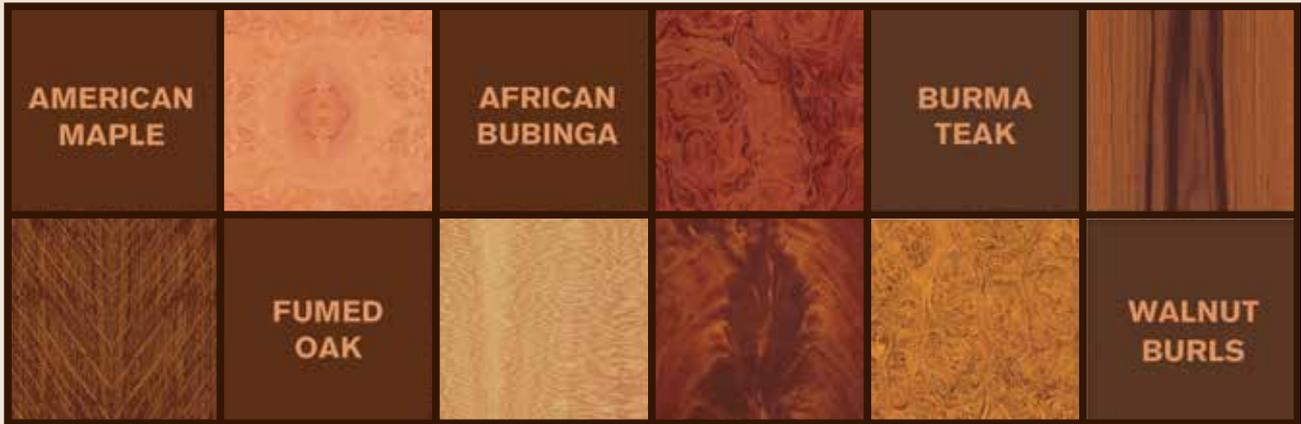
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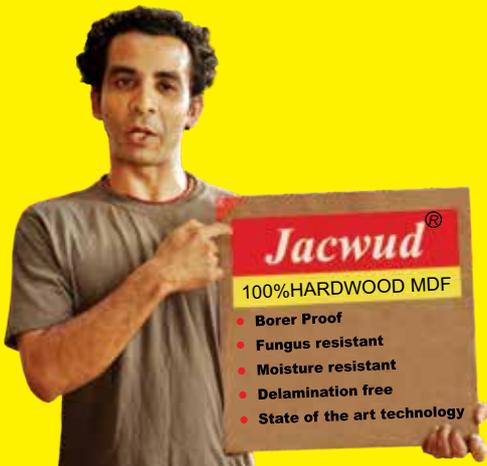


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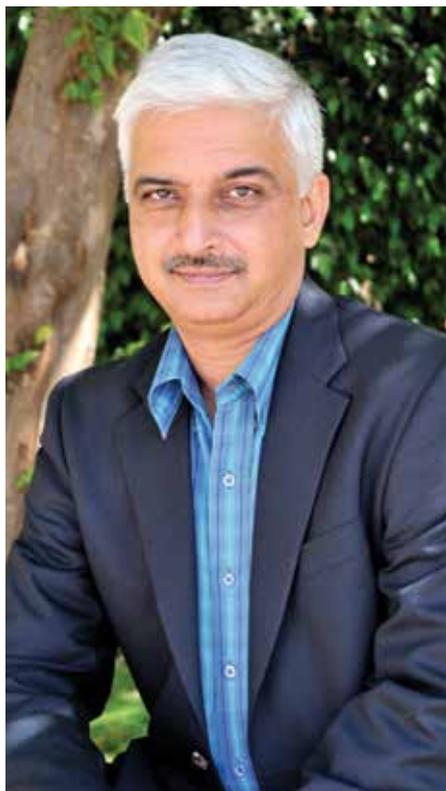
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# EDITORIAL



## Hello Readers!

Like they say, 'better late than never'. That stands true for the errant monsoon this year, which was causing anxious moments for the government, the farming community and people in general. While the newly-elected government is still to show concrete direction or signs of hard resolve to kick-start the flagging economy, its 100-odd days in power have passed by with unwavering positive sentiment in the markets and the populace.

But some unmistakable signs of hope are showing through, and Venjakob's increasing confidence in the Indian market is one example. Its CEO, Mr. Christian Nuesser, was in Pune recently to inaugurate its 'made-for-India' spray painting booth, the Smart-II. An interaction with Venjakob's top-brass in July gave me the impression that the German specialist would not have undertaken this expansion if it didn't know its marbles.

In short, the burgeoning real-estate sector (hotels, resorts and residential properties) in the country is luring more and more manufacturers into investing in high-performance machinery. And if big desi manufacturers are already in the fray, it won't be long before multinationals begin engaging with India's techno-commercial expertise and thirst for business expansion.

Another indication came from the country's first installation of a New Zealand-make edge banding machine: it not only pointed to the re-awakening of the woodworking industry, but also brought home the point that not all technologies are complicated and/or costly: something Indian investors are very wary of! Moreover, the evolving field of contour edge banding is offering consumers a plethora of choices, and manufacturers a choice of solutions. Exciting times, right?

We also have in this issue two areas of concern: the continued use of volatile organic compounds in many woodworking additives, mainly in adhesives and finishes, and ignorance of norms. These, among other factors, are not only a matter of concern to those unsuspecting consumers using such furniture, but is also a stumbling block for the woodworking industry in the country to make a mark in the export market. With such widespread ignorance and callous disregard of manufacturing standards and health-related concerns, global biggies (such as Ikea) are bound to be hesitant in their procurement from Indian producers.

I am sure most of you are receiving the fortnightly *WoodNews* e-newsletters. If not, write to [editor@woodnews.in](mailto:editor@woodnews.in). You can also feature your products, share your news, or advertise through these e-letters! We are now also updating our website more frequently, and will shortly launch a brand new one. Happy reading.

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# Venjakob makes 'smart' move to India

Venjakob Maschinenbau GmbH, the German specialist in pre-treatment, painting and drying, handling equipment and air filtering systems, is taking its India market and operations seriously. In an exclusive chat with *WoodNews*, Venjakob CEO, **Mr. Christian Nuesser**, and Venjakob-India Director, **Mr. Ronnie Palat**, say Smart-II is the first of many machines to be custom-built for the sub-continent's requirements.





### What drives Venjakob into setting up a manufacturing base in India?

**Nuesser:** Obviously, we have volumes in mind. The furniture manufacturing potential in India has been huge for a number of years. We feel the time is now ripe to enter India with a manufacturing base, where we cater to this growing market, at a price that will be difficult to resist!

We are starting with the wood and furniture sector and with entry-level machines. We will further build on our brand and strengthen our servicing and marketing networks. But we are also looking to expand with machines that will cater to the finishing requirements in the automobile, steel and plastics industries.

### What really was the turning point?

**Palat:** After general elections in India, we have seen a number of enterprises, both in the organised and unorganised sectors of woodworking, take up new challenges. The hotels and resorts sector is seeing a boom, thereby raising the demand for furniture.

That in itself was not enough: the end consumers of these facilities have been exposed to high-standard furniture and living, and their expectations of finished products and services are very high. It is this that has forced furniture manufacturers to look for viable solutions to high-precision and top-quality finish.

### How is Smart-II 'made for India'?

**Nuesser:** We have had some years of experience in this country and recognise the needs and specifications of our customers. Once our customer has ordered a machine, he can even inspect it under production at the Pimpri plant, because we will be manufacturing it to his specifications.

We encourage our customers to visit the factory, to understand the nuances of the machine's functionality, because it is critical to his mission. The Smart-II

has a bigger booth, but the line speed remains the same, as does the exacting quality of German manufacturing. We now manufacture about four machines per year, which will be scaled up to one per month in 2015.

### What will be the advantage to Indian buyers?

**Palat:** Basically our buyers will no longer have to bear the burden of import duties and related taxation. That itself will result in a 30% price advantage. Apart from that there is a considerable degree of customisation to their needs, which transforms into flexibility. Add to that the assurance of prompt after-sales service and ready availability of spares within the country, and you have a deal-clincher.

There has been a large but unfulfilled demand for finishing lines in India for many years. We have had a lot of fence-sitters who balked at the cost of technology. They also doubted the quality of after-sales service and availability of spares. Now, with Venjakob-approved expertise and production in India, they will have no reason to defer their investment decisions!

### Smart-II is now being made in India.

#### What next?

**Nuesser:** Smart-II is really only our first step. We also have very attractive treatment solutions for the wood furniture industry involving cleaning, drying and dust-extraction. The great advantage in investing in Smart-II is that, at a later date, the other systems can easily be integrated into a full-fledged Venjakob finishing line.

#### When will that happen?

**Nuesser:** We will surely begin manufacturing our other machines in India. A decision and road map is expected to emerge by the end of 2014, after further deliberations and diligence with our business partners. ▶

### Who are your existing and potential customers?

**Nalavade:** We have many customers who are suppliers to large projects like hotels, high-end residential interiors, shop fittings and kitchens. We have installed machines and finishing lines for the likes of A&A Modular systems

in Mohali (Punjab), who manufacture the Aida and Aura lines of modular kitchens; then there is Westwind Solutions (shop fittings), Vector in furnishing office spaces, Soundarya in Chennai who do high-end villa interiors.

Our latest customer is Godrej Interio

in Mumbai. Our future customers will be the 'fence-sitters': mainly middle-level furniture manufacturers with no brands or showrooms of their own, but with large projects to execute.

*(Mr. Nitin Nalavade is CEO, Nitshaw Surface Technologies, distributor for Venjakob).*

## Smart-II will now be 30% cheaper



Venjakob CEO, Mr. Christian Nuesser, inaugurating the 'made-in-India' spray painting booth, the Smart-II, at the Pimpri (Pune) factory.

Venjakob India, a subsidiary of the renowned German machinery manufacturer, launched its 'made-for-India' spray coating machine, the Smart-II. At a well-attended function of its Indian employees, distributors and existing and potential buyers, Venjakob also arranged a visit to its new factory premises in Pimpri (Pune) on 30 July, where the Smart-II

was unveiled by its CEO, Mr. Christian Nuesser.

The Indian production of the stand-alone, small-footprint painting solution will reduce its price tag by about 30%; but its adherence to strict German manufacturing standards is guaranteed. It can be used for solvent and water-based paints. A quick change between the two paint systems is

simple and fast, making it especially attractive for smaller companies to replace manual painting.

The Smart-II is widely used in the painting of wooden furniture, kitchens shutters, moldings, windows, doors and floors. It also finds applications in painting of steel pipes, plates, girders, seals and rims, automobile and solar panels, fibre cement boards, roofing tiles, leather and composite materials.



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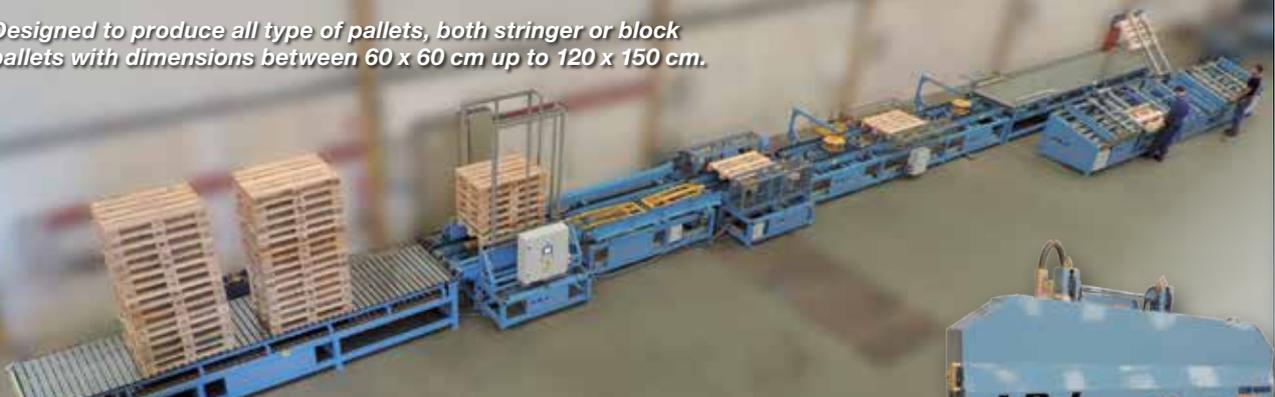
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# Formaldehyde is a matter of concern



 L-shaped office work station.

*Pic: Amazon Wood, Pune*

## By Nitin Vaze

The reclassification of formaldehyde by the International Agency for Research on Cancer as “carcinogenic to humans” has triggered enormous concern globally. Office furniture is a functionally needed utility value, keeping in view the ergonomic design for good working conditions.

Good lighting and aesthetics enhance office interiors. One of the most neglected aspects in India is the awareness to keep the level of formaldehyde emissions to acceptable levels in office interiors. These are released from the furniture, more particularly from wood-based panels used in the fabrication of furniture, such as plywood, block board, particle board and medium density fibre board (MDF).

Formaldehyde exposure potentially causes a variety of adverse health hazards, such as eye, nose, throat and skin irritation, coughing, wheezing and allergic reactions (see Table). Long-term exposure to high levels of formaldehyde has been associated

with cancer in humans. Formaldehyde can affect people differently. Some people are very sensitive to formaldehyde at a certain level, while others may not have any noticeable reaction to the same level.

Formaldehyde levels in indoor air can vary depending on temperature, humidity and air exchange rate within the indoor space. In addition, several studies have shown that, in the presence of ozone, formaldehyde levels increase; therefore, the outdoor and indoor ozone levels are also relevant.

Formaldehyde levels in internal office spaces may change with the season, day-to-day, and day-to-night. Levels may be high on a hot and humid day and low on a cool, dry day.

Measuring formaldehyde emissions from individual consumer products is difficult because a variety of products in the office can release formaldehyde, or trap formaldehyde emitted from other sources. Products with greater emissions and larger surface areas in the office will most likely have a

greater contribution to indoor air formaldehyde levels.

We keep this in mind when categorising different product types:

**Wood-based products:** Pressed wood (hardwood plywood, particle board and MDF) especially those containing UF resins, may be a significant formaldehyde source.

**Wallpaper/ paints:** Moderate levels of formaldehyde are released initially after application. Some paints are now found with low-VOC (volatile organic compounds) formulations.

**Other materials:** Formaldehyde can be created from the chemical reaction between ozone and other VOCs during the use of personal computers, laser printers and photocopiers.

**Re-emitters:** Because they are porous, products such as carpets or gypsum board do not contain significant amounts of formaldehyde when new. However, they may trap formaldehyde that is emitted into the air from other products and later release it into the indoor air.





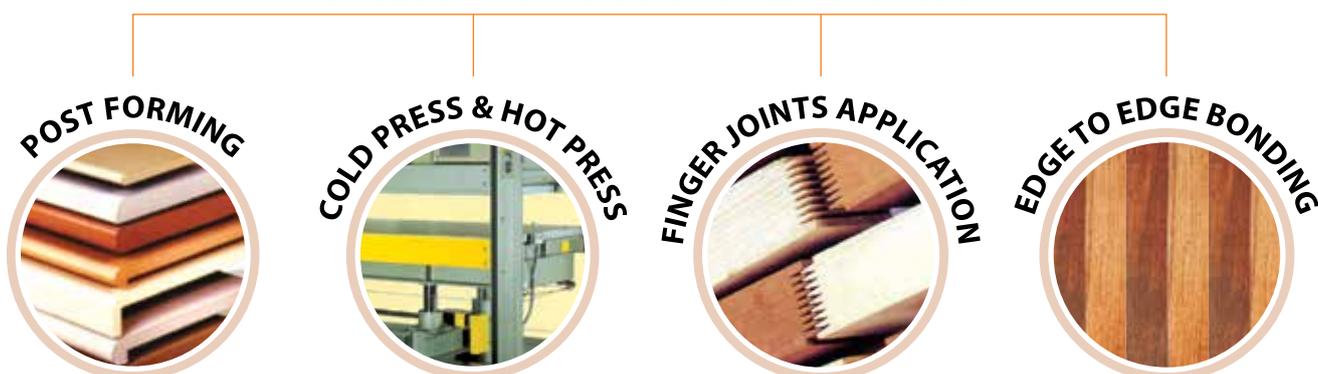
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Formaldehyde exposure can cause a variety of symptoms and potential adverse health effects. A person's ability to smell a chemical odor, such as formaldehyde, does not always mean that the levels of the chemical are of concern, or will cause an adverse health effect. Therefore, some people can smell formaldehyde before being adversely affected by it.

You can reduce exposure to high levels of formaldehyde by installing wood floors or finishes that are not 'acid-cured', which is a type of finish that is formaldehyde-based. When installing pressed-wood products - such as particle board, MDF or hardwood plywood - for construction of office furniture and interiors, ensure that it is stamped in compliance with E1 emission norm at the most minimum.

Several safety standards are in currency across the globe, but the main ones are CARB (California Air Resources Board) P1&P2, the North American voluntary standards ANSI, the E2, E1 or E0 European emission standards (most imported products from Asia are E2 or worse), and the F-star emission standards set by the Japanese Industrial Standards. (See table for classification).

There are panel products even lower than E1 such as E0, or CARB P2 available in market. Attention and concern is required from all office furniture manufacturers to purchase wood panels having the minimum E1 certification for the safety and health concern of the people working in the office environment for which they supply the furniture made in their factories. Buyers also must make conscientious decisions while ordering furniture.

*The writer is a well known figure in the world of panel products in India and abroad, having been in the business for several decades. His company, Sleek Boards (India) LLP, is one of the country's leaders in marketing a variety of technologically advanced panel products.*



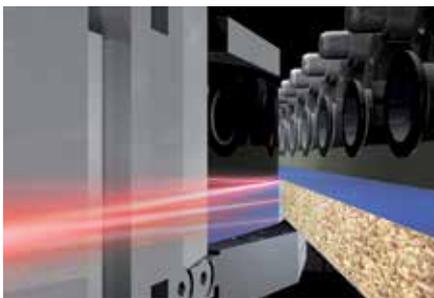
Common adverse effects on health from formaldehydes	
Affected Areas/Systems	Potential adverse health effects
Eyes	<ul style="list-style-type: none"> <li>• Stinging, burning, itching</li> <li>• Excessive tearing</li> </ul>
Nose and Throat	<ul style="list-style-type: none"> <li>• Stinging, burning, itching</li> <li>• Sore throat</li> <li>• Running nose</li> <li>• Blocked sinuses</li> <li>• Sneezing</li> <li>• Cancer</li> </ul>
Respiratory	<ul style="list-style-type: none"> <li>• Chest tightness</li> <li>• Wheezing</li> <li>• Asthma</li> </ul>
Skin	<ul style="list-style-type: none"> <li>• Allergic contact dermatitis</li> <li>• Skin rashes, blisters and flaking dry skin</li> </ul>
Neurological	<ul style="list-style-type: none"> <li>• Headaches</li> <li>• Mood changes (depression, irritability)</li> <li>• Insomnia</li> <li>• Attention deficit</li> <li>• Nausea</li> <li>• Impairment in dexterity, memory, equilibrium</li> </ul>

International composite board emission standards.			
Composite Board Emission Standards	Product	Formaldehyde Emission Limits	E1333 Equivalent
CARB-P1	HWPW	0.08 ppm	0.08 ppm
	PB	0.18 ppm	0.18 ppm
	MDF	0.21 ppm	0.21 ppm
CARB-P2	HWPW	0.05 ppm	0.05 ppm
	PB	0.09 ppm	0.09 ppm
	MDF	0.11 ppm	0.11 ppm
ANSI A208.1, A208.2	PW	0.2 ppm	0.20 ppm
	PB	0.3 ppm	0.30 ppm
	MDF	0.3 ppm	0.30 ppm
E2	PW	30 mg/100 g	0.38 ppm
	PB	30 mg/100 g	0.38 ppm
	MDF	30 mg/100 g	0.38 ppm
F** / E1	HWPW	0.12 mg/m <sup>3</sup>	0.14 ppm
	PB	0.12 mg/m <sup>3</sup>	0.14 ppm
	MDF	8 mg/100 g	0.10 ppm
F*** / E0	HWPW	0.5 mg/L	0.07 ppm
	PB	0.5 mg/L	0.07 ppm
	MDF	0.5 mg/L	0.07 ppm
F**** / SE0	HWPW	0.3 mg/L	0.04 ppm
	PB	0.3 mg/L	0.04 ppm
	MDF	0.3 mg/L	0.04 ppm





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# Particle board is NewGen material



 Virgin particle board is widely used in numerous projects for multinational corporate offices.

The furniture industry in India is growing at a healthy pace and interesting materials are introduced to the market each year. Some materials are tested and discarded; some are used, researched and moulded to be gradually absorbed into the experimenting and evolving markets; some materials change the face of the industry.

Looking back, it is difficult to imagine the world without the latter kind of material. In terms of engineered wood products such as medium-density fibreboard (MDF) and particle boards, the Indian furniture industry is plagued by speculation, assumption, doubt and farfetched notions.

As market leader, Associate Décor Ltd. considers it its responsibility to spread awareness about this product segment. A number of reasons for not considering particle boards and MDF can be addressed if correct information is provided to the users

about the 'new generation', eco-friendly material.

Life has become more complex in a world increasingly augmented by technology, living spaces are re-defined in more inclusive terms, the products and artefacts that fill these living spaces have evolved to offer more relevant solutions.

Even office furniture space is going through a complete metamorphosis. The corporate world has changed in almost every aspect. Gone are the days where offices would have heavy wooden furniture.

There is an increasing demand for sleek and convenient furniture of modern offices. Particle boards are becoming the next big thing in the world of office furniture.

Mr. Ashok Quadros, Director of MultiFlex (Mumbai) says, "Particle boards as a material have absolutely no problem. We have been using it for

the last 24 years to service numerous hospitality projects and projects for multinationals, running into millions of square metres of space. We don't have any issues because we use virgin particle board (boards made from a single species)."

Mr. Ganesh Kudva, Director of Pentavision Pvt. Ltd. (Bangalore), points to the efficiency of timber. "The number one advantage is economy and environment friendliness. The efficiency of timber usage is as low as 20% in the case of solid timber and 50% in the case of plywood," he says.

In the case of particle boards, the usage of timber is 150%, because even when the trees are growing, it is the trimmed branches that go into the particle boards, Kudva notes. The timber is extracted while the tree still stands. "This is the commercial advantage," he adds.

The second major technical advantage is that reconstituted boards do not have a directional property disadvantage – the particles are arranged in such a way that grain-wise or cross-wise the directional properties are the same. "So, if you hammer a nail into a particle board, it will not crack like plywood or timber,"



 Reconstituted boards do not have a directional property disadvantage, and can withstand various woodworking processes.



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Kudva stresses.

The use of MDF and particle boards has dramatically grown the world over, increasingly becoming a replacement for solid wood and plywood applications. However, due to the lack of awareness and misconceptions about the material, particle board



 *Advancements in technology and manufacturing have reduced formaldehyde emissions in particle boards.*

has not been widely accepted in the Indian furniture industry, especially in the residential segment.

But particle boards have many advantages. Apart from being a cheaper and convenient alternative to wood and plywood, they are also eco-friendly and have less emission than plywood. Changes and advancements in resin technology and improved manufacturing controls have dramatically reduced formaldehyde emissions in particle boards.

Kudva adds, "The emission levels come into play in the corporate sector in spaces like the IT and business parks, where the whole unit is air-conditioned and the same air circulates internally. Continuous exposure to permissible levels of emission need not be carcinogenic, but it can result in lower productivity."

Though the use of E0 and E1 particle boards make the product costlier, the health hazards are drastically reduced. Unfortunately, this thought has not come into the industry yet. It is only large multinational corporations that use low-emission particle boards.

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# On the learning curve with edge banding



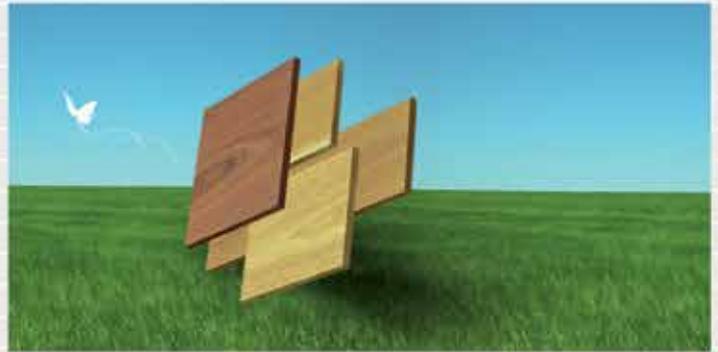
In a market crowded with woodworking machinery and technology, what stands out about New Zealand-based Vector Systems is the simplicity of the design and working of its contour edge banding machine, the Revolution-180. Dhananjay Sardeshpande met with Vector Systems founder, **Mr. Duncan Such**, in New Mumbai recently, to find out what makes his invention tick.



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Long after you first set eyes on Mr. Duncan Such, founder of Auckland-based Vector Systems, what stays in your memory is his casual demeanour and sartorial simplicity.

It is this trait that has perhaps percolated to the design, manufacture and working of his hugely popular invention, the Revolution-180, a curvilinear edge banding machine that has made an entry into India.

WoodNews caught up with him soon after the installation and commissioning of his first machine in India at Merino Industries in Hapur. Still fresh from his travel, and undaunted by the summer heat of Ghaziabad (Uttar Pradesh), he spent time in Navi Mumbai to explain his invention and record his impressions about woodworking in India.

How important is the global edge banding market? Duncan is effusive when he says that contour/ curvilinear edge banding is only in its infancy, and stresses that there are great possibilities in the near future.

“Design around contoured panels, be they particle board or MDF, is a recent trend. Can you imagine the variety of furniture that will emerge out of these (non-linear) panels?” he gushes.

#### Business to Invention

So what is special about Revolution-180? First, it is a PLC (programmable logic control) machine and an attractive alternative to expensive CNC (computerised numerically controlled) machines, says Duncan. At the same time, the quality of work is comparable, if not better than that accomplished on CNC machines.

This results in substantially higher returns on investment: the price of the Revolution-180 is a fraction of CNC machines, and it works best at high speeds, saving time. Low “down time” is built into its DNA: its simplicity and fewer drive systems enable ease of maintenance and repair by a qualified technician.

What is more, adds Duncan, the PLC-driven system engages in simultaneous processing of feeding, gluing, taping, trimming and surface scraping operations. The separate machining centre can simultaneously produce components, exponentially increasing flexibility and output.

And the patented SideWinder unit enables the tape to be trimmed in the same pass as the gluing and tape application. The end-of-tape sensor mechanism precisely measures the tape position, enabling a tight and consistent join for closed panels, Duncan informs.

He should know what he is talking about: Duncan has been running a business importing and selling

“  
The “landing cost” of a Revolution-180 is approximately Rs. 2.35 crore. Vector Systems is represented in the country by Esskay Services, which also lends support and service to its Indian clientele.

woodworking machines and tools into New Zealand for more than two decades. So why the shift from trading to manufacturing?

Duncan’s wide experience with machinery and his demanding clients, along with his exposure to woodworking technologies gleaned from visits to international trade shows – including IndiaWood 2012 in Bangalore – led him to realise the need for a simple machine for curvilinear edge banding.

In 2004, he put his engineering

education to work to design and manufacture the Revolution-180. His business sense led him to take on the new challenge of marketing his invention in the face of well-established CNC machine manufacturers worldwide. Duncan was lured by the challenge of mastering all aspects of business: the idea, the design, the engineering, logistics and marketing. “The idea and opportunity was just right,” he beams. The fact that Vector Systems has so far installed 40 of these machines – from the US to Japan, Russia to Saudi Arabia, and Australia to Ireland – stands testimony to his engineering and business acumen.

#### India Calling

The commissioning of his first machine in India also points to Duncan’s realisation of the country as one with great potential. And he is more than impressed by the level of sophistication in woodworking in the organised sector. “I asked many investors and business heads in India: ‘When labour is so cheap, why go in for such machinery?’”

The answers he got impressed him equally. “Indian manufacturers (of furniture) are as quality-conscious as their demanding customers!” Duncan informs. On the repercussions of bad quality, he says: “Often the purchasing manager tries to cut costs in glue or tape procurement, little realising that it can result in reworking finished pieces, or rejection from the dealer/ customer. Poor finish and lack of durability is counterproductive to any brand and its business.”

He is glad that decision-making in private sector enterprises in India is decentralised and proactive. “It took me four years for my breakthrough in the US: there were layers of bureaucracy, even in multinational corporations, who took their time in arriving at decisions. Here (in India) the purchasing process is easier and faster,” he notes.



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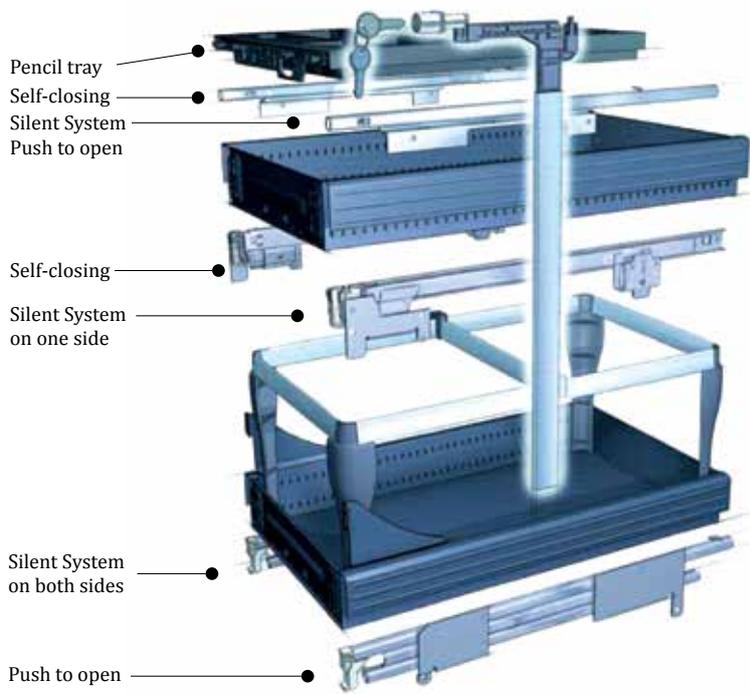
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# Advanced office furniture from Hettich



In today's competitive world, premium offices have become a part of the brand value of companies. Employers are found to be more sensitive towards employee wellbeing. We also know that people perform better at work where offices are well designed, pleasant and well equipped to reduce stress and physical exertion.

Added to that individuality in organizing the space people work in is the key to ensure they feel good working there and their output is optimized. With the role of technology becoming dominant over any other aspect in furniture industry, the constantly growing need for ergonomics and comfort at work cannot be ignored.

This makes it even more important for every organization to have the right work stations and systems in place to boost employee efficiency and ensure high employee motivation. It thus turns out to be the ultimate decisive criteria in attracting best human resource.

With its all-embracing expertise in technology for furniture, Hettich

creates synergies for the work environment. For instance, innovative features, like Soft Close-Silent System and the push-to-open function in drawers and wall storages are now available for the office furniture, apart from the ergonomic convenience of work table height-adjust facility.



Hettich is well established as an important partner for the office furniture industry and has the expertise – and over 125 years of experience – with innovative fittings and systems for the furniture industry as a whole.

## Systema Top 2000

The perfect solution for a well organized office, it makes efficient use of storage space with perfect organizers for drawers to suit your customers' specific needs.

Systema Top 2000 is not just a high quality, double-wall steel drawer system with concealed runners which has evolved over time into a perfect drawer system for the office. It also has organizers to customize individual preferences.

The tried and proven Systema Top 2000 modular system provides noticeable quality for the user and huge flexibility for the furniture manufacturer. Whether traditional, mobile or dividing up space, Systema Top 2000 modular system provides the basis for limitless design flexibility,





just a change of few components define function and quality level, with runners and drawers remaining the same.

'Auto Self-Close', 'Built-in Silent System' and 'Push-to-open' functions provide options to suit different needs and budgets.

#### LegaDrive

This is a perfect 'ergonomic' solution for working tables with an electrical height adjust system for tables.

Keeping in mind the consumer's demands of safety, stability, noise emission, energy consumption, adjustment speed and stroke, Hettich designed the innovative LegaDrive.

LegadDrive system adjusts the desk

top to the chosen height (625-1300 mm) simply at the press of a button. Infinite variability with swift and easy action allows the user to find the ideal working position at the desk – whether sitting or standing. The powerful and silent lifting mechanism and variable height adjust is impressive.

It has a lifting capacity of 80 kg per column, and for desks with two columns, a capacity of 120 kg, even in motion!

The column's design blends harmoniously into modern work environments and comes in three surface finishes: anodized aluminum, white and anthracite. There are no

cross-members and all working parts being fully concealed, it caters to office aesthetics and provides furniture-makers with the great design flexibility.



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# Jai has a bouquet of options

Panel processing machines perform various operations on panel boards: straight and curved cutting, laminating, edge banding, multiple boring, special carving, moulding, CNC routing, pasting, etc.

They can be used to produce furniture, specialized interiors and mass manufacturing wood- and panel-based products and components. Commercial interior and furniture is the fastest growing market.

Ahmedabad-based Jai Industries proposes a list of machines for a factory set-up to manufacture office furniture.



**Edge Bander (Model J-3000.in manual)**

Whether you choose furniture making, interior services or panel-based products, edge banders are an integral part of putting finishing touch to all panel edges. Jai offers 'J-3000.in', the curvilinear edge bander for melamine, veneer & PVC or ABS to the non-linear edges. Straight edges also can be used.

It takes edge material thickness from 0.5mm to 3mm, and board thickness of up to 60mm.

Auto edge banding machines, such as the 'J-4000.in' and 'J-4000R.in' are used for edging the required materials of veneer, melamine, PVC or ABS to the linear edges. Edge thickness 0.4-3mm, board thickness 11-45 mm and feed speeds of 6 metres per minute.



**(Model J-4000R.in Auto Radius Trim)**

There are machines mainly required for mass production of straight panels. Radius trim function is also available

for manual chamfering of panel corner.

The 'J-4000R' is a sturdy, heavy-duty machine to suit Indian working conditions for precise application of edge banding material with round cornering of veneer, melamine, PVC or ABS. Edge thickness 0.4-3mm, board thickness 10-50mm and dual feed speed of up to 14 metres per minute.



**Panel Saws (Model J-3200.in Plus)**

They are suitable to cut chip-free all kind of laminated chipboard, including MDF, HDF & panels. They help you cut panels to your required measurements, from 8x4 feet to 9x6 feet.

The 'J-3200.in Plus' offers top quality sliding carriage for smooth action and lasting accuracy. The carriage is on hardened ground, and uses prism guides for precise cutting. For those operating on a small scale, the 'J-3200.in' panel saw is ideal. If scales are bigger, the 'J-3200.in Plus' or European-quality machines from SCM are also available.

**(Model J-5100 PRC.in Auto)**

It is easy accessible and has a user-friendly PLC touch-screen control panel positioned at machine in-feed, for quick operations. It is mainly required for mass production of straight panels.



**Edge Trimmers** (Model J-3003R.in manual Radius Trim)

The 'J-3003.in' and 'J-3003R.in' are designed for the trimming of edges in PVC (up to 3 mm) and board thickness of 10-55 mm. It comes with a buffing unit for better finishes and end cutting. They are mainly required only if an edge bander (auto) is not purchased. The radius trim function is also available for manual chamfering of panel corners.



**Multi-Boring Machines** (Model J-2102.in Double Head Multi Boring)

The 'J-2102.in' is purposed for vertical and horizontal drilling to the surface or edge of the work piece. A pneumatic cylinder achieves lifting of drilling unit with 21 spindles. It bores holes in various sizes in pre-destined

positioning, thus making production faster and finer. Models are available in single, double and triple heads, and are mainly suitable for making knocked-down furniture.

**Dust Collectors** (Model DC-32)

These are a must as supportive

equipment with machines like panel saw, spindle moulder and through-feed auto edge bander, for dust-free environment. They make your men and machine work better and longer by keeping them healthy.

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## Sleek shine with magnetic glass dividers

With changing work environments and thrust on creativity and comfort, modern offices cannot overlook the impact of their interiors on the brand of their company. Office furniture also need to fulfill every aspect of a contemporary work place: it cannot just be functional but needs to take into account the aesthetics and multiple uses.

Dividers for modular work stations is one such aspect which contributes amply to the aesthetics and multi-functionality of an office. Bangalore-based Vishwa Safety Glass Pvt. Ltd. manufactures coloured, shatter-proof, laminated glass dividers, 'Vishwa Spanlam', used exclusively in open office modular work stations.

The new magnetic laminated glasses, 'Vishwa Maglam', add a new dimension to modern office interiors. These opaque glass partitions come in a variety of shades. The magnetic dividers have a metal laminate inserted between the two sheets of glass, an innovation that multiplies the functionality of the product.

VSG Director, Mr. U. Pradeep, sheds some light on various advantages of these dividers over traditional ones. "On these glasses, you can write with a marker, erase it, and write again. You don't use paper, it's environment-friendly, you save on the cost of pins and paper. That's the advantage over wood or metal partitions," he says.

You can stick a pamphlet, leaflet etc. on the magnetic glass. Some offices use the magnetic board on top of the already existing wood or metal divider, which means 3 inches of the wood or metal divider, plus the additional thickness of the magnetic board. But with Vishwa Maglam, it is less than a centimeter thick, saving on space! Tiny magnets are strong enough to hold more than 10 sheets of paper together.



Vishwa Spanlam (left), Vishwa Maglam (right).

### Aesthetics

"You get these partitions in 40 colors. You can beautify your work environment, giving a sleek and shiny look to your office interiors. You can choose the colour of the glass to match with other aspects of the interior, such as the carpet or walls," Pradeep notes.

Each traditional divider has a thickness of about 75mm. With these glasses you save around 70mm/7cm. If you consider each work station to be of 1x1m<sup>2</sup>, you will save around 1m<sup>2</sup> of area for every 20 work stations.

Glass screens are also maintenance-free, unlike fabric partitions that get dirty or accumulate dust. What is more, the glass doesn't retain stains and always looks brand new.

"All these glasses are shatter-proof. If you hit this glass with a hammer, it will crack, but will stay at place, it won't come out with flying shards," Pradeep says, adding that the

lamination inter-layer between the two plates holds the glass together.

### Installation

Installation is easy. With the traditional dividers, you need a stand from the floor and the desks are mounted on the stands of the divider. Whereas, these glass dividers are mounted on the top of the tables, with clamp fittings. You only need to drill two holes on the furniture, not the glass, and insert the clamps that hold the glass in place.

VSG is a Bangalore-based OEM supplier to modular furniture manufacturers in India. Considered as a desirable product in office furniture industry, the new laminated glass dividers, both magnetic and non-magnetic, are currently at the core of their marketing activity. The glossy glasses with smooth edges are all finished on imported machinery. ([www.vishwalammi.com](http://www.vishwalammi.com)).

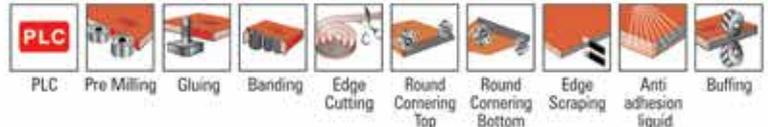


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# Biesse's solution to manufacturing automation



The photocell safety solution allows maximum use of pendulum working field.

Biesse's new Rover Gold G is a CNC machining center with a gantry structure for processing office furniture. The rigidity and reliability of the gantry structure is combined with compactness and flexibility of the working center, making this machine an ideal solution for manufacturers looking to automate production.

Specially designed for office furniture processing, the Rover Gold G can satisfy all the requirements of manufacturers who would like to enhance their productivity in a small investment.

## Operating unit configurations

The operating unit can be configured as per the manufacturer's need. The machine has the following options:

### Configuration 1

BH 30 Boring Head (20 vertical drills + 8 horizontal drills + 2 saw blades along X & Y) + Electrospindle 13.2kW ISO

30/HSK F63.

### Configuration 2

BH 17 Boring Head (10 vertical drills + 6 horizontal drills + 1 saw blade along X) + Electrospindle 13.2kW ISO 30/HSK F63.

### Configuration 3

BH 17 Boring Head (10 vertical drills + 6 horizontal drills + 1 saw blade along X) + 6kW Vertical Router with ER 32 Collet.

### Configuration 4

BH 17 Boring Head (10 vertical drills + 6 horizontal drills + 1 saw blade along X) + Electrospindle 13.2kW ISO 30/HSK F63 + 5kW Horizontal Router with ER 32 Collet.

## Work table

The working table of the Rover Gold G is 3200-mm long and is available with widths of 1260 mm or 1560 mm. The robust ATS working table is equipped

with the pneumatic locking carriages and ensures an optimum locking of the pieces.



Many references are available for the processing of several pieces.



Ergonomic auxiliary vacuum outlet for customized jigs.



Revolving tool changer with 16 places. Installed on the X carriage, it has tools and aggregates always available, therefore reducing tool change time.

### Operator's safety



Anti-projection safety strips guarantee full operation and total safety in accordance with regulations in force.

### Control panel

- Microsoft Windows operating system controlling the machine
- Biesse Works user interface; axes real-time control; input/outputs management; real-time execution of machine logic; bar code reader ready; optional connection of a laser profile projector; specific machine function enabling buttons.

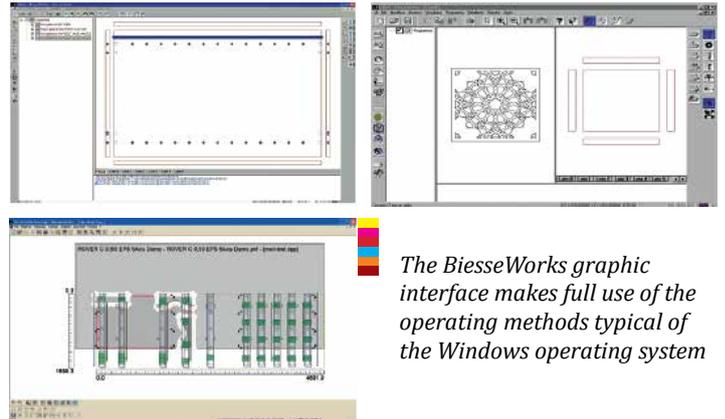


PC-based BH660 numerical control.

### Software

Assisted graphic editor used to program machining operations; parametric programming and guided creation of parametric macros; import of CAD and other external software files in DXF and CID3 format.

([www.biessemanufacturing.com](http://www.biessemanufacturing.com))



The BiesseWorks graphic interface makes full use of the operating methods typical of the Windows operating system

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6. Wood working machinery
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# Ornare high-gloss panels offer multitude of possibilities

High-gloss finishes for office furniture are becoming a popular choice, with designers and customers wanting a flat, reflective, scratch-resistant finish without the weight and expense of glass or tedious process of painting.

The challenge with high-gloss acrylic is to get a flat finish without ripples and dimples that distort the reflection, and with a depth of gloss to get a mirror-like finish.

This mystery has been cracked by Ornare, which recently launched a sophisticated range of premium Acrylux high-gloss panels made at its

state-of-the-art manufacturing facility in Gurgaon.

Polished, sleek and contemporary, Ornare panels are made to suit every furnishing need. The must-have piece of the puzzle that completes every ideal home or office, these panels are manufactured with the utmost finesse and precision using the revolutionary PUR technology, incorporating the finest raw materials from all over the world.

Each Ornare panel is crafted with a passion to showcase versatility and sophistication at its best. Available in

solid, metallic and wood-grain hues, there is no limiting what an interior designer can create with the multitude of possibilities they present.

Environment-friendly, free of hazardous tin-organic contents (chlorine) and heavy metals (lead, chromium V1), recyclable and child-friendly, each panel offers peace of mind, no matter where it is affixed. The water-resistant and fuss-free nature of the panels takes ease of care to the next level.

With functionality, design and cutting-edge technology all featured in the Ornare panels, your dream office is no longer just a dream. It's now your reality. Furniture made out of Ornare will bring a fresh look with personality to your workplace.

Acrylux panels come in 24 colours on varying substrates like MDF or plywood and different thicknesses, either single- or double-sided. The surface is always supplied with a protective film. The standard panel size is 2440 x 1220 x 18MM.

Larger quantities can be supplied with HIPS or matching HPL on reverse side also, as opposed to the standard white melamine on stock range. Ornare compliments its panel collection with matching and contrasting edge band solutions.

*([www.ornare.in](http://www.ornare.in))*





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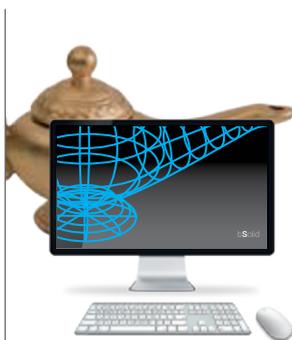
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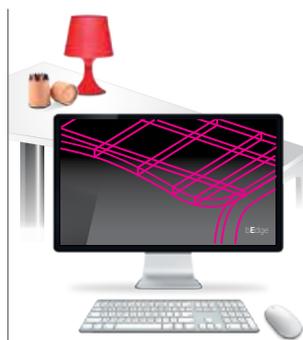
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# Contour edge banding from Vector Systems



The Vector Revolution-180 quite literally turns contour edge banding on its head and represents the first significant development of machinery in the composite board industry since the development of CNC machining centres some 20 years ago.

The Revolution 180 is entirely new concept in both its manner of operation and the fact that it is only responsible for edging the panel, not for cutting out the shape. It has no CNC programming: the patented Revolution-180 process is controlled by a PLC with a simple and intuitive colour interface.

It has a cartridge glue system with quick setting for different board thicknesses; has prismatic bearings for all axes and has a wide working area (Y axis is 1800 mm). It has no complex programming, no time-consuming set-up and no issues of interfacing with existing machining centres.

The Revolution-180 concept is ideal because it fits easily with traditional component manufacturing methods as well as nested-based manufacturing. The operator essentially only needs to think about how to place the panel on the machine. By reading table markings, a start position is saved into the PLC controller. With a bit of planning, it is possible to use the same start position for many different shaped panels.

The Revolution-180 is the first contour edge bander to adopt 'simultaneous processing', where all functions are performed simultaneously, rather than sequentially. Its PLC and control console can be easily moved by the operator to make for ease of loading

and unloading the machine. The PLC enables common settings for product types (such as glue temperatures, start and park positions) to be saved.

The Revolution-180 uses a clever suspension mechanism to control the trimmer and (optional) surface scraper. The flat blade scraper removes any surface glue as well as trimming excess caused by variations in panel flatness. As with the trimming and glue units, the scraper can be turned on or off from the control panel.

The VECTOR Revolution 180 uses a cartridge and nozzle glue system which precisely controls the glue onto the tape (matching the width of the panel) so the off-cut top and bottom is glue free for perfect trimming. A wiper blade cleans the nozzle prior to each cycle ensuring the leading edge of the tape is free of glue for perfect butt joins.

The Revolution-180 is equipped as standard with a large field size enabling 1830mm in the Y direction and 3500mm in X. This, matched with the flat work-surface allows vacuum cups to be positioned very flexibly for very large components as well as allowing pendulum operation for maximum output.

It is capable of handling a wide variety of shapes and component sizes, including external corners as small as 19mm radius and internal corners of 50mm internal radius. Square corners are also simple to achieve with the use of vacuum pods with lead-in and lead-out edges.

The Revolution-180 uses a simple but sophisticated means of sensing the

shape of a panel and effectively writes its own program as it progresses. The patented Sidewinder trimmer unit enables the tape to be trimmed in the same pass as the gluing and tape application. The end-of-tape sensor mechanism precisely measures the tape position, enabling a tight and consistent join for closed panels.

## Panel Dimensions

Thickness:  
38mm to 16mm (optional 15mm)

Y dimension: Maximum 1830mm

X dimension: Maximum 3600mm

## Technical specifications

Rigid machine frame for long life, stability

Prismatic bearings for all axes

PLC control with colour screen user interface

No pre-programming required.

Patented SideWinder trimming system

Cartridge glue system with quick setting

Minimum external radius 20mm

Minimum internal radius 50mm

Minimum banding thickness 1mm

Maximum banding thickness 3mm

Flat bed configured for pendulum operation

Panel lifting pods for large panels

0.75kW trimmer motor

Two radius knife heads

Quick change vacuum pod system

Power consumption 7.5KW.

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capable system, Eubiq allows your clients to add, remove and reposition power outlets anytime anywhere, with just a simple twist.

The extensive range of architecturally versatile tracks are designed for use in a wide range of applications: residential use includes kitchens, living rooms, study rooms, audio-



 The architecturally versatile tracks of the Eubiq are designed for a wide range of applications.

video rooms, master rooms and floor skirting.

Among its commercial uses are system furniture, server rooms, display counters and test laboratories.

Not only is it ultra-safe and quick to install, the system can carry electrical currents of up to 32 Amp and offers freedom of movement. Its architectural versatility and modular concept result in cost saving.

Hafele India offers a diverse range of quality products, well-networked channel partners and unmatched service to its customers. It is also the sole distributor in India to Blum, the Austrian kitchen fittings manufacturer and world leader.

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# K700-S: the 'heroic' panel saw



Cutting is generally the first process that is carried out in any woodworking workshop. Your Felder panel saw K700-S -- for that matter any other panel saw from Felder -- is meant to give you not only perfection and precision but also a boost to the other processes of woodworking by giving you the desired results and finishing in one go.

The Felder K700-S has proved to portray a heroic image in the workshop, considering its qualities of being strong, accurate and reliable. This is the reason that Felder has been considered as India's leading European-built panel saw manufacturer.

The K700-S has been designed to deal with the often extreme conditions encountered in Indian workshops. The factors that were considered while developing the K700-S were taken from an extensive research and feedback gained from the close association of hundreds of Felder customers itself.

It is very essential for customers to understand that, especially in the capital goods industry, there is no purpose served by setting a budget without prior consideration of the end use. Investing right at the first go will not only eliminate the chances of reinvestment but also reduce your "down time".

Strategizing on investment plans is the most crucial process of your workshop; it will ensure your production runs in line with your planning.

## Heart of the Machine

The sliding table and saw unit are core components of a panel saw, hence one of the most important features when looking to invest. The accuracy of the sliding table and saw unit are

the main factors in determining the straightness of the cut.

Another aspect to bear in mind is that the majority of workshops are hot and dusty environments, which can mean a lot of maintenance work of the guidance system or repairing it once built-up dirt causes it to jam.

The Felder sliding table guidance system 'X-Roll' has widely been recognised in the industry as one of the best on the market. Independent tests by respected industry magazines have confirmed that the unique linear bearing contact between the sliding table and base provides a distinctively smooth sliding action with absolutely no sideways play throughout the full length of the stroke.

The integrated three-way dust protection system ensures the guiding system remains in top condition. The 'X-Roll' sliding table is backed by a six-year factory guarantee.

The Felder heavy duty saw unit is completely enclosed in a cast-iron housing and is supported on both sides with cast iron trunion segments. The industrial-strength synthetic

tilt segments is completely eliminated. The material is in use with large earth-moving machinery for many years now and is virtually wear-free. The 'Easy-Glide' system is also backed by a six-year factory guarantee.

## Scoring Unit

The scoring unit is a small saw blade positioned in front of the main blade and is a crucial part of the panel saw as it prevents tear-out when working with melamine boards. Tear-out is the damage created by the main saw blade snapping the melamine layer outwards as it exits the underside of the board.

The shallow cut made by the scoring blade removes the melamine layer below the board, therefore preventing tear-out. The advantages of having a scoring unit are therefore highly visible on the finishing quality of the cut, as both the upper and lower sides of the board have a clean edge.

The ability to accurately align the two blades further improves the cut quality dramatically. The Felder system allows the operator to work from above the blades, giving him a clear view of the alignment.



material 'Easy-Glide', which sits between the male and female trunion components, ensures absolutely no lubrication is required in these segments.

With 'Easy-Glide' the common problem of dust clogging the greased



The Felder Group has five different panel saws available to suit any need. Ultimately however, the machine should adapt to the work piece, as opposed to the other way around.



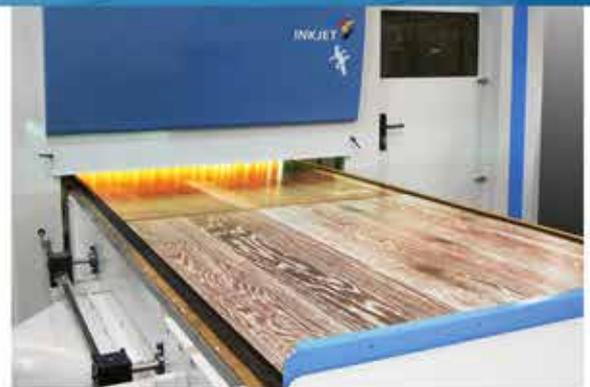
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# Understanding durability of wood adhesives

**By Jeremy Hunter**

With the Indian government permitting 51% foreign direct investment in retail in early 2013, various multinational corporations, such as Ikea, are looking forward to entering the Indian furniture market.

Some high-ranking industry players – Godrej & Boyce Manufacturing Co. Ltd., Space Wood, Renaissance, Millennium Lifestyles, Durian and Tangent among them – are also engaged in this business.

This has created a strong need for local and standardized manufacturing of modern furniture in India. With nearly 85% of the production base contributed by the unorganized sector, there is a need to follow international protocols and standards. In order to cater to the customers to provide quality furniture, manufacturers need to use quality raw materials and solutions.

One of the most critical raw materials in any furniture which can significantly enhance or diminish furniture's quality and durability is the wood adhesive. For this reason, the right knowledge of various types of adhesive available is necessary.

There are various durability classes of adhesives, which are adopted keeping in mind the climatic conditions where the end product will be kept and area of application. The most important European standards for classification of wood adhesives are:

- EN 204: thermo-plastic wood adhesives for non-structural applications applicable to furniture, window frames, interior structures;
- EN 205: wood adhesives for non-structural applications (reference to determination of tensile shear



 *Class D2 adhesives are used, among various applications, for thermal lamination of timber products.*

strength of lap joints);

- EN 14257: wood glues determined by adhesive strength of longitudinal bonds with tensile tests and heat exposure;
- EN 14292: determined through resistance to static stress and heat exposure;
- EN 14256: wood adhesives for non-structural applications, tested with different testing method and requirements for resistance to static stress.

These standards are adopted (ISO standard) to avail common classification of wood adhesives with respect to durability classes, and to provide unique liability system with regard to properties guaranteed by an adhesive manufacturer.

As per EN 204, four different stress

classes are defined: D1, D2, D3 and D4. These are durability classes measured after various conditioning treatments (temperature, humidity & other different testing process).

## **Class D1**

These adhesives are used for interior areas, where temperature doesn't exceed 50°C and moisture content of the wood is maximum 15%. Usually the application area is limited to laminate overlay and solid wood edge lamination.

## **Class D2**

This class of wood adhesives is applicable for interior areas, with rare short-term exposure to running or condensed water and/or occasional high humidity. The moisture content of the wood, however, does not exceed 18%.



The use of Class D1 adhesives is limited to laminate overlay and solid-wood edge lamination.

These adhesives may be used for various applications like laminate overlay for veneer finish, solid wood edge lamination, doors, windows, wooden floor assembly, sandwich panels, wood and timber products veneering, plank joints, block glue for hard and soft wood, surface gluing and thermal lamination of timber products.

However, it needs to be noted that these adhesives are usually used for home furniture manufacturing. The D2 system is applied for lamination of window frames and window corner joints. In the manufacturing of doors and windows, special requirements such as heat and water resistance have to be fulfilled.

**Class D3**

While D3 class is applicable for interior areas, where regular short-term exposure to running or condensed

water and/or heavy exposure to high humidity is presented. Exterior areas are not exposed to weather.

D3 durability class is implied for laminate overlay, solid wood edge lamination, doors, windows, post forming, finger joining, sandwich panel (wood-paper honey comb-wood) and flooring assembly.

This is usually adopted for kitchen furnishings and mainly applied for parquet and laminate floors, for (tongue-and-groove joint) gluing and



Class D3 glues are mainly used for (tongue-and-groove) joint gluing and moisture sealing.

moisture sealing of various joints.

**Class D4**

This class of adhesives are applicable for interior areas with frequent long-term exposure to running or condensed water. Exterior areas exposed to weather, but only with

surface coating protection.

This class is adopted for laminate overlay, solid wood edge lamination, doors and windows, finger joining, sandwich panel (wood-paper honeycomb wood), and flooring assembly.

It is applicable for bathroom furnishings or wet rooms like kitchen and outdoors use. D4 systems are used for manufacturing of furniture and built in components for baths. Glue for outdoor applications with required surface protection can also be completed by D4 systems.

Henkel Adhesive Technologies India offers solutions for the wood & furnishing industry. It has different applications for each durability class: the Aquence PL-151, Aquence PL-41 and Aquence PL-161 in D2, the Aquence KL-472FF, Aquence KL-4662 and Aquence KL-4971 in D3 and Aquence SL-463 in D4.

Wood adhesives are crucial for Indian wood and furniture industry. What goes behind the scene in manufacturing branded, quality, designer furnishing is not just aesthetics, but various inputs. Better the quality of inputs, more durable the furniture.

*The writer is President, Henkel Group-India.*

Stress class	Storage life	Required bond strength
D1	D1-1 storage 7 days at SAC	>10 N/mm <sup>2</sup>
D2	D2-1 storage 7 days at SAC	>10 N/mm <sup>2</sup>
	D2-2 storage 7 days at SAC. Storage of test specimen in cold water (approx. 20°C) for 3 hours.	>8 N/mm <sup>2</sup>
D3	D3-1 storage 7 days at SAC	>10 N/mm <sup>2</sup>
	D3-3 storage 7 days at SAC. Storage of test specimen in cold water (approx. 20°C) for 4 days	>2 N/mm <sup>2</sup>
	D3-4 storage 7 days at SAC. Storage of test specimen in cold water (approx. 20°C) for 4 days.	>8 N/mm <sup>2</sup>
D4	D4-1 storage 7 days at SAC	>10 N/mm <sup>2</sup>
	D4-3 storage 7 days at SAC. Storage of test specimen in cold water (approx. 20°C) for 4 days	>4 N/mm <sup>2</sup>
	D4-5 storage 7 days at SAC. Storage of test specimen in boiling water for 6 hours.	>4 N/mm <sup>2</sup>

Classification of thermoplastic wood glues according to their water resistance (EN-204). The tests have to be carried out with specimen prepared according to EN-205. Standard ambient conditions (SAC): 23°C at 50% relative humidity, or 20°C at 65% relative humidity.



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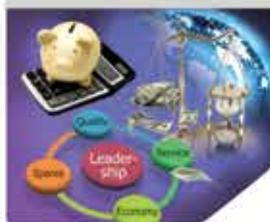


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# Innovations ensure Leitz remains global leader

**Leitz has always remained the global leader in providing complete tooling solutions for machining of wood, plastics and other non-ferrous materials. The overriding strength of Leitz worldwide has been its constant R&D efforts in products and process improvements and innovations have been the hallmark of these efforts. A few such innovations, which are relevant to Indian industry, are presented here:**

Raw material shortage, increased material costs and an uncertain supply are ongoing trends the woodworking industry has to face. Reducing the use of the expensive raw materials is the first step to controlling costs.

In the future the Leitz philosophy of re-sharpenable constant diameter and the profile tooling systems will become increasingly important, compared to traditional throwaway systems.

But saving costs is only half the contribution to reduce customers' costs. A cheaper tool does not influence the tool life, nor the follow-up costs: sharpening, tool change time, setup time and production down time.

The key to improving the tool efficiency or the production process is the run time performance of the cutting edges. "Profit is made at the cutting edge" goes the adage, and by increasing the run time performance, the cost per running metre can be reduced significantly.

Increasing the run time performance requires innovative cutting material, independent of the type of tipping. High speed steel (HS) becomes increasingly wear-resistant by adding more alloys; but it entails increased costs of raw material and production.

Tungsten, with a smaller grain size and a greater binder percentage, improves the wear resistance. The focus is to increase wear resistance where it is necessary – at the cutting edge – and not throughout the cutting material.



Leitz's approach to solving this problem is 'coating', the process that combines opposing material characteristics such as hardness and toughness. This knowledge has been successfully employed for decades in the metal processing industries and is now indispensable.

Wood production demands a different wear mechanism and geometry. Thermal stresses and cutting forces are lower and the cutting edges need to be much sharper. The importance of maintaining a sharp edge over a long period has excluded the use of coated tools in wood production.

To its HS mini finger-joint cutter and planer knife, Leitz has added coated tools to the production range with great success. These are coated with a special layer developed by the Leitz coating plant.



HS tools for solid wood production with this patented coated surface achieve a run time performance increase of 3 to 5 times, compared to uncoated tools. Following this positive experience it is Leitz's objective to develop a complete programme of coated tools for solid wood production.

The principle of coating creates round edge. The layer forms a film on the sharp ground cutting edge. Even if the layer thickness is only few microns, a coated ground cutting edge, when cutting wood, has the same effect as a blunt tip: wood cells are deformed by the high cutting pressure.

This disadvantage is avoided by sharpening the cutting face after the coating process. The exact procedure depends on the tooling systems: if the rake face is coated (knives) or the clearance side (profile cutter) is coated.

The coating layer is significantly harder than the base substrate. A coated HS blade has hardness in the range of tungsten. This procedure generates not only a sharp cutting edge but also improves the wear resistance.

More base material is removed than the thin coating layer, with the effect that the cutting edge will not be rounded but it is worm out "sharp-edged".

## Advantages at a glance

- Up to 6 times the performance of uncoated tools
- Constant sharp cutting edge
- High processing quality

## Application for coated tools

- Sawmill and moulding
- Timber construction
- Stair construction
- Window production
- Bead production
- Parquet production
- Furniture production
- Plastic processing

The result is long-lasting high cut quality, leading to an increased tool 



*WE SHAPE THE FUTURE*

## **High Precision Tools & Tooling Systems from the 138 year old World Leader**

### **Cutting Solutions For:**

- Wood & Wood Derived Materials
- Plastics & Non-Ferrous Materials
- Calcium Silicate / Fibre Cement / Mineral Boards
- New Generation Composite materials etc.



### **NEW CUSTOMER SUPPORT INITIATIVES FROM LEITZ INDIA:**

- CARRY OUT TOOL AUDIT AT CUSTOMER'S FACTORY by Leitz Engineer to list out their product mix, machines, materials being machined etc.
- TOOLING SELECTION REPORT prepared and explained to the customer. The report includes most appropriate tool selection, application parameters and remedies to common defects – both for existing product / materials mix as well as future possibilities.
- CONDUCTING SEMINARS/WORKSHOPS at customer's factories to familiarize the technical / shop floor personnel on efficient usage and maintenance of tools.

**Leitz Tooling Systems India Pvt. Ltd.,**

No. 486-C, 14th Cross, 4th Phase, Peenya Industrial Area, Bangalore – 560 058

Tel: 91+80-28364834 / 28364898 / 28364928, Fax: 91+80-28364870

Email: [info@leitzindia.com](mailto:info@leitzindia.com), Log on to : [www.leitzindia.com](http://www.leitzindia.com), [www.leitz.org](http://www.leitz.org)

life of up to six times compared to uncoated tools

The inspiration is beavers, they cut wood day-on-day, but still have sharp teeth! We have a one-sided hard-coated surface combined with a lower wear-resistant tougher base material, creating a self-sharpening effect.

The balance of these two materials is the result of a longer evolution process that achieves the desired wear resistance effect. Leitz sees a huge potential for improving the specific wear-resistance in solid wood processing, matching the substance and the coating surface.



A Marathon-coated edge (above) retains a sharp cutting edge even after 3,000 running metres, compared to an uncoated one (below).



As a novelty Leitz also tackles coating of hard metal tools. Due to the high basic hardness (over 2000HV), the surface hardness should exceed it. The innovative nano-structured coating layer reaches a hardness of over 4000HV and is suitable for this application.

The first cutting test results are promising and show significantly higher wear resistances, compared to uncoated hard metal. This results in doubled tool run time.

Coated tools for solid wood production are efficient for many reasons. Because of the increased

tool life (compared to uncoated tools) the additional investment is quickly recovered, and the cost per running metre is significantly reduced.

For some applications, the tool life of coated HS tools surpasses that



of uncoated tungsten-tipped tools. Substitutions of tungsten tools with coated HS tools reduce both new and sharpening costs.

The target group for Leitz coating programme is the primary industry – sawmills and planing mills, structural timber, stairs, window production, blanks, parquet and furniture production.

### Windows and Doors

Modern plastic window profiles place high demands on saw blade cut quality and life time because of the use of high-quality surface

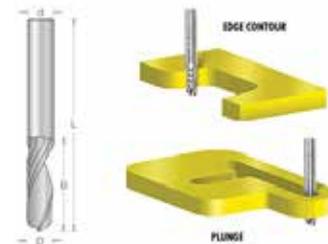


coatings and fibreglass reinforced plastics. Leitz has developed diamond-tipped saw blades meeting all these requirements.

These saw blades are available in 6 diameters, and field trials have shown that after 2,000 cuts this innovative saw blade is more economical than conventional tungsten carbide-tipped saw blades.

### Transparent result

Acrylic Glass (PMMA) is a material frequently used in modern furniture

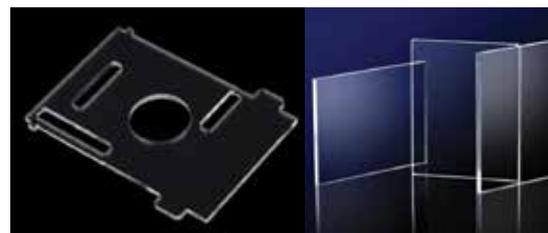


fittings. Achieving transparent results when machining this material in one step – and without the need for additional finish polishing – high precision tools with low tolerance are essential in terms of run-out, concentricity and axial eccentricity.

The 'GlossCut' saw blade has characteristics to meet this objective, as have MKD-tipped (mono-crystalline diamond) routers and drills because of their unique cutting geometry.

GlossCut saw blades are used on table and panel sizing saws with or without scoring saws, vertical panel sizing saws and double trim saws running against the feed (both top and bottom).

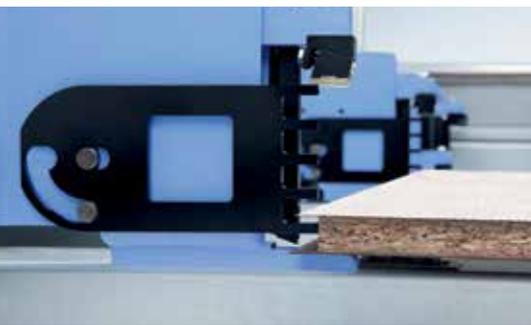
The excellent cut quality of GlossCut saw blades is a must for those who want to raise the quality of work pieces machined from transparent thermoplastics to gloss quality with



little additional costs.

The finish cut quality of the cut surface of coated wood-derived materials is also improved with GlossCut saw blades used with a scoring saw. Previous secondary machining to the work piece – such as additional machining to the cut edges before polishing or flaming – is eliminated.

The high cut quality is achieved by specifically developed tooth geometry to minimize tooth marks. As well as the increase in cut quality, noise level is reduced by up to 4 dB(A) by use of vibration damping laser ornaments. 



## HOLZMA HPP 230 and HPP 250: Diversity right from the start

With the HPP 230 and HPP 250 you are ready to meet all your customers' demands.  
And the best part: upgrading is allowed! Your HOLZMA saw can grow in line with requirements.

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New! 19" TFT flat screen monitor with touch functionality
- **Efficient:**  
Optionally available with the automatic feeding system Easy2Feed or with storage link-up
- **Powerful:**  
55 or 80 mm saw blade projection, saw carriage speed from 60 to 120 m/min, available in 3 200 / 3 800 / 4 300 mm cutting lengths
- **Flexible:**  
Optionally available: grooving, trim stops, laser guide beam, labeling, postforming, machine table with air jets and much more



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The 2 series in action



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# More precise, more adaptable



 *The new plunge-cut saw, TS55-R, sets new standards.*

More than 30 years ago Festool revolutionized the market for circular saws with its plunge-cut saws. It is once again raising the bar decisively with the new TS55-R.

Even more precise, more adaptable and easier to use – the new TS55-R plunge-cut saw has even better handling characteristics and, thanks to the superb detailed finish, offers more application possibilities than ever before.

The inner suction supports lend the

saw its flat and continuous planar housing. Virtually boasting no bulges on its surface, it makes possible proximate sawing up to a minimum wall distance of 12mm.

It is thus designed for precise sawing of joints on floors and ceilings, as well as for trimming doors. Shadow gaps and expansion joints can also be created quickly using this tool. The only portable machine for chip-free and splinter-free cut.

The tried-and-tested spacer wedge

typical of Festool circular saws has also been completely redesigned. It primarily represented a high standard of safety, but as a spring-loaded guide wedge it now helps deliver even more precise results.

In comparison to the previous spacer wedge, its new design allows it to protrude from the housing before the saw blade; hence it can be positioned (for example) by moving the guide rail into the existing flat joint to guarantee perfect and straight continuation of the cutting edge.

**FESTOOL**

# Perfect edge with a system .



As the basis for the perfect edge, Festool's CONTURO system, is complete end to end integrated solution. Right from a clean cut or routing the sheet material, to the gluing application, pressing the edge, end cutting and flush or radius trimming, through to glue scrapping edge scrapping and finally sanding and polishing – the Festool system makes everything possible in an equally professional and clean quality that was previously only possible with stationary machines



Cleaner glue cartridge system: Simple insertion, perfect metering.



Edgebanding : (0° - 47°) in stationary application.



Exact End Cutting of the edge using the KA 65/2.



Trimming with Chamfer / 2mm / 3mm radius with the MFK 700.



Glue Scraper & Edge Scraper with Integrated Radius.



Polishing & Buffing Kit.

[www.festool.com/CONTURO](http://www.festool.com/CONTURO)  
Contact for Live Demo: [sales@caple.in](mailto:sales@caple.in) +919930069903



Undercuts are now also possible with the extended setting range between  $-1^\circ$  and  $47^\circ$ .

### Angle setting

The angles between  $0^\circ$  and  $45^\circ$ , which are required most frequently, can be

selected conveniently and directly with the tab locations. That there are hardly any precise angles on building sites is an open secret to professional tradesmen.

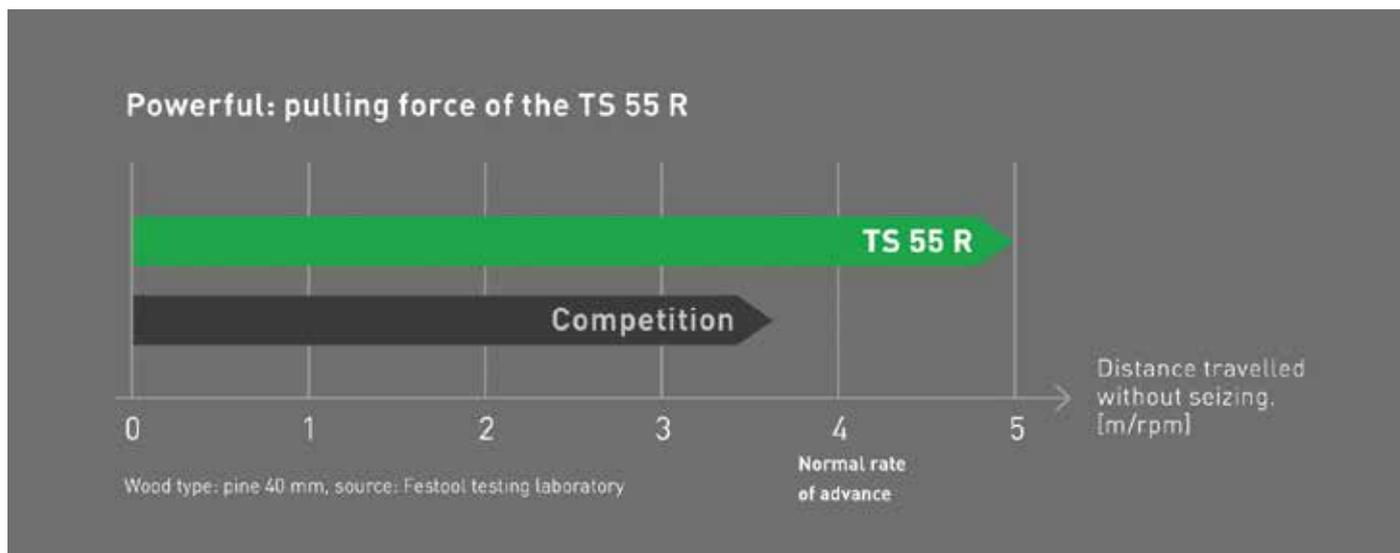
This matter was taken into consideration with the new TS55-R: with the new enlarged angle setting between  $-1^\circ$  and  $47^\circ$ , undercuts and exact corner solutions can now be created easily.

Sometimes extremely precise plunge cuts are in demand, for example when cutting worktops for kitchens. Festool has also created a practical aid for this application because a transparent viewing panel allows an optimal view

of the saw blade and the marking on the work piece.

The result: the cut ends precisely at the point where it should end. For day-to-day work the double cutting depth scale with fine adjustment ensures precise results. Cutting depths with or also without a guide rail can be read and set or adjusted quickly and easily.

Together with the guide rail the special splinter guard guarantees clean and splinter-free cuts on both sides. Guidance jaws that can be adjusted without using any tools allow the plunge-cut saws to slide on the guide rails without any play.



The high-power TS55-R achieves an in feed rate of 5 metres / minute.

### Pure power

Festool focuses on high power with its TS55-R. For the tradesman this means that he achieves an infeed rate of 5 metres/minute when sawing – and without being obstructive! This is thanks to the plunge-cut saw's powerful motor, the special gear reduction ratio, as well as the MMC electronics.

The usual Festool features – smooth

start-up, temperature and overload protection, as well as triple-engine mounting – ensure long life and quick braking for safety.

Festool has redefined 'classic' with the TS55-R and created even more application possibilities. It can also be converted to a stationary bench saw with the compact module system. The track takes away the operator skill required for cutting and your first cut is your final cut!

### Technical data

Power consumption	1200 W
Idle engine speed with electronics	2000-5200 rpm
Idle engine speed without electronics	6500 rpm
Saw blade diameter	160 mm
Angle range	$-1^\circ$ to $47^\circ$
Cutting depth	0-55 mm
Cutting depth	0-43 mm
Proximate sawing (joint width)	Min. 12 mm
Weight	4.5 kg

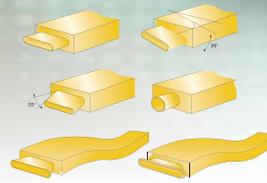
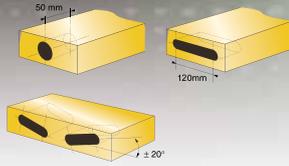


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# WOODNEWS



NOV-DEC 2014

Special  
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MODULAR KITCHENS

The Nov-Dec 2014 issue of *WoodNews* will focus on Modular Kitchens, Kitchen Fixtures, Fittings & Accessories, Edge Banding Materials, Machinery & Software. The magazine will also have bonus circulation at 'ACETECH 2014' in Mumbai, besides being circulated among Builders, Dealers, Project Managers & Architects.

The issue will also specially be sent to all office bearers and senior members of the

**Indian Institute of Architects (IIA)** and **Indian Institute of Interior Designers (IIID)**

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# Max power for dry walls

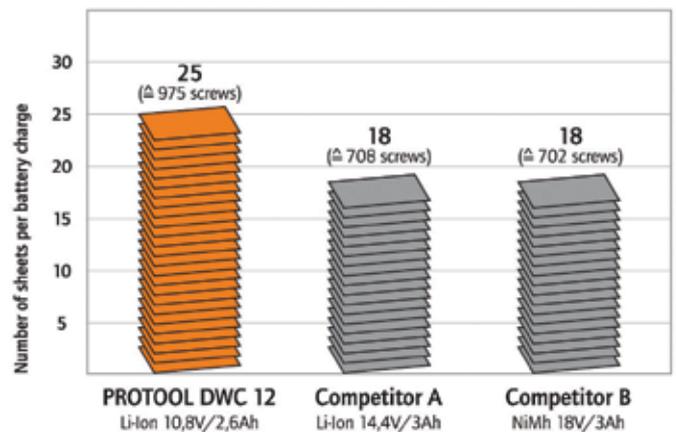


 Festool's DWC 12-4000.

DuraDrive DWC 12-4000 DEC Li dry-wall screwdriver from Protool was developed for continual use in professional drywall applications. The specially developed machine operates at the perfect speed for drywall applications and allows the user to secure gypsum plasterboard to the base frame structure precisely and with minimum effort.

Due to an ergonomic shape and design, the 1.7kg DuraDrive rests snugly in the hand and is perfect for inserting loose screws or strips of screws with a magazine attachment. It can fasten 975 screws per battery charge.

**Fastening capacity per battery charge**  
Hanging plasterboard on metal studs: 3.9 x 35 mm,  
using 39 screws per sheet\*



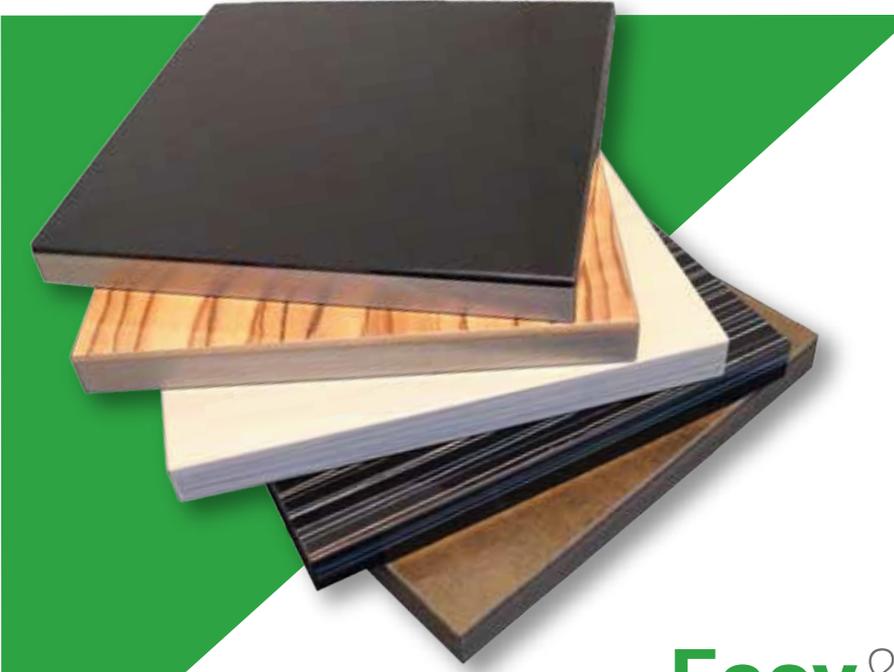
\*Board thickness 12.5 mm, thickness of metal stud face 0.6 mm  
Source: PROTOOL testing laboratory 2009.

 Fastening capacity comparison.

The staying power of the tool can be attributed to features such as the electronic cut-out, Li-ion battery technology, EC-TEC motor and an innovative start/stop function, and is far greater than any of its competitors. The function ensures that the motor only starts when a screw is inserted.

The user can even activate 'auto' mode to perform this task automatically without pressing the main switch. Simply position the screw and apply pressure to insert. Pressing a trigger continuously is now a thing of the past.

During continuous use, the DuraDrive simplifies the work of drywall professionals considerably while simultaneously providing a customized solution for the precision insertion of large numbers of screws within a very short time. 



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## Jade 200 Series

Automatic Throughfeed  
Edgebanding Machines

The all new Jade 200 Series, completely packed with all the features the industry has waited for at a low investment!





# Making light of heavy tasks



 *The GCM 12 GDL Professional.*

The light and compact tools from Bosch are designed for top-notch performance while consuming the least of energy and being environment-friendly. The cordless tools run on powerful yet green-conscious Li-ion technology from Bosch.

A sprawling campus in the heart of Bangalore houses the innovation centre for Bosch Power Tools. Its learning campus has a concentrated accumulation of knowledge and

learning media for application of power tools, training traders, craftsmen and woodworking enthusiasts in batches.

A visit by *WoodNews* was welcomed with live demonstrations of a range of power tools for woodworking. Bosch's quality is incredible in the finishing and precision they achieve with any sort of wood, be it sawing, sanding, screwing, nailing or even measurement.

Bosch Power Tools recently invited *WoodNews* to its Bangalore learning campus, for a sneak-peek into its wide array of offerings for the woodworking sector.

**Suraj Uprety reports**





This machine provides for unmatched cutting smoothness and durable precision. Beautiful cross-cuts at any angle with highly smooth and maintenance-free gliding system. Dual line laser enhances the cutting accuracy along both horizontal and vertical lines.

It has a patented Axial-Glide™ system that can accommodate up to 110 mm (height) and 341 mm (width) cutting. It comes with improved upfront bevel controls, integrated dual-line laser and a square lock quick release fence.

Tech Specs	
Cutting capacity, 0°	103 x 341 mm
Cutting capacity, 45°	mitre 104 x 240 mm
Cutting capacity, 45°	incline 51 x 341 mm
Mitre setting	52 ° L / 60 ° R
Incline setting	47 ° L / 47 ° R
No-load speed	3800 rpm
Saw blade diameter	305 mm
Saw blade bore	30 mm

**Scope of supply:** dust bag (1 609 B02 595), insert plate (1609 B02 375), saw blade 305mm 80 teeth, vertical clamp (1 609 B02 585) and wrench.

*Founded in 1886, Robert Bosch GmbH, of Stuttgart, Germany, has been one of the top suppliers of technology and services worldwide, operating in 150 countries and employing around 3,00,000 employees. Since its inception in India in 1993 Bosch Power Tools division has become a market leader.*

# Table saw GTS 10 Professional



A powerful tool for its size, it runs on a 1800-W motor for the hardest of jobs, speedy cutting up to a depth of 79 mm, but with complete ease of handling. Cutting capacity is up to 635 mm to the right and 330 mm to the left of the saw blade.

It has a large workbench (641 x 737

mm) with high cutting capacity, along with a spindle lock for easy saw blade changes. Its patented 'square lock' parallel guide results in absolutely accurate saw cuts. An angle guide can be integrated in the basic machine frame. It also has safe storage for saw blade and assembly tool in the saw blade depot.

Tech Specs	
Table size	641 x 737 mm
No-load speed	3650 rpm
Saw blade diameter	254 mm
Saw blade bore	30 mm
Incline setting	47 ° L / 2 ° R
Max. cutting capacity on the right	635 mm
Max. cutting capacity on the left	330 mm

**Scope of supply:** Circular saw blade storage compartment (2 605 430 008), push stick (2 607 001 914) and saw blade (254x30mm).

# Line Laser GLL Professional

For the uninitiated, line lasers are modern devices that draw (highly) accurately vertical and horizontal lines on a wall/screen. These devices are a combination of spirit level and plumb bob that project absolutely straight illuminated lines on any surface, a necessity in interior designing and cabinetry, kitchen and wardrobe installation.



 The GLL 2-50 Professional Line Laser.



 The GLL 2-80 P Professional Line Laser.

Tech Specs			
Models	Line Laser GLL 2 Professional	Line Laser GLL 2-50 Professional	Line Laser GLL 2-80 P Professional
Tech aspects			
Working range	10 m	20 m	20 m
Leveling accuracy	0.3 mm/m	0.3 mm/m	0.2 mm/m
Self-leveling range	± 4°	± 4°	± 4°
Laser class	2	2	2
Dust and splash protection	IP 5X	IP 54	IP 54
Power supply	3 x 1.5 V LR6 (AA)	3 x 1.5 V (AA)	4 x 1.5 V (AA)
Tripod connection		1/4"	1/4", 5/8"

Other Features		
Line Laser GLL 2 Professional	Line Laser GLL 2-50 Professional	Line Laser GLL 2-80 P Professional
Small, lightweight, always within reach	Self-leveling horizontal and vertical pendulum line laser for quick alignment of lines	Leveling in 2 x 360° – Faster and easier than ever
Easy handling due to single-button operation	High visibility of the laser lines with a working range of 20 m (without receiver)	High work efficiency: simultaneous performance of horizontal and vertical leveling applications in the entire room with only one tool
For flexible use: with multifunctional mount for versatile fixing possibilities	Extremely precise in use with an accuracy of ± 3 mm at a distance of 10 m	Large working range: precise work in a diameter of up to 80 m using the LR 2 Professional Receiver
Good visibility: min. 10 m (depending on ambient brightness)	Vertical, horizontal, and cross line modes for precise alignment	Easy handling: self-leveling up to 4° within 4 seconds, compact design
Professional leveling precision: 0.3 mm/m	Easy handling due to single-handed operation	Scope of supply: Batteries 4 x 1.5 V (AA), Magnet target plate, Protective pouch
Scope of supply: Batteries 3 x 1.5 V (AA), Multi-function mount (1600A000J3), Protective pouch	Horizontal and vertical self-leveling up to ± 4°	
	Working range of 50 m with the Receiver LR 2 Professional (optional)	
	Robust design with soft grip covering protects against knocks	
	Pendulum lock ensures safe transport	
	Scope of supply: Alignment disc (SP no. 1 609 203 U23), Batteries 3 x 1.5 V (AA), Protective pouch	

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**FORMAT**

# It's the fine details that make a perfect panel saw ...

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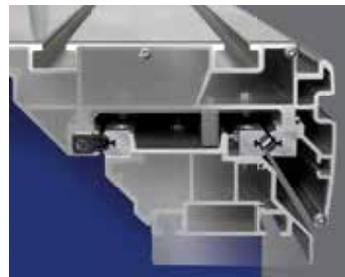
- Cutting height 5¼" (133 mm)
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- 3 scoring systems to choose from
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- Unique Felder "Easy-Glide" tilt system with 6 year warranty
- Automated rip fence with perfect repeatable accuracy



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**ALL PARTICLE BOARDS MAY LOOK SAME!!**  
**BUT ARE NOT THE SAME!!!**

**AS PER EN 312 BOARDS FOR FURNITURE AND**  
**INTERNAL FITMENTS MUST BE OF TYPE P2**

Particle Boards have set a revolution in the engineered wood panel trade since 1960 globally and in India post 1980's and the demand has escalated in leaps during this century. Particleboards are products of high technology and technical configurations and are highly performance oriented. Several furniture manufacturers are buying huge volumes of particle boards to process in their factories and the biggest challenge is to know if the buyer is paying for the quality for a board which looks more or less the same externally but internally has a large play field to be "tailored" by the manufacturer based on price demands of buyer. Some Questions and Answers to clear the mist around

**Why is choosing the correct Particleboard important in determining the quality of your furniture.**

Particleboard is an engineered product capable to last a decade withstanding the daily use abuse just like plywood if used of the right quality with the right Modulus of Rupture, Modulus of Elasticity and Internal bond properties. HeveaBoard specialized in producing Low Emission Particleboard which do not compromise on mechanical properties.



**Why does door hinges loosen after some time?**

Holding hinges is a property of the construction of the board. If the board has a low internal bond the hinges loosen within short time and can cause the shutter to come loose from the carcass.



**Why does cabinet shelves started to warp after some time?**

Sagging or warping by placement of any weight on the shelves is caused by the board having poor modulus of rupture. A poorly produced board can sag even by its own weight!!!



**Why is my furniture made of particleboard swell?**

Swelling is a natural reaction to moisture for any wooden product however the resin formulations inhibit swelling to large extent to less than 8% after 2 hours immersion. However compromise on the resin additives and formulations will cause reflection on furniture by display of the swelling.



**Why are Bending Strength and Internal Bond of Particleboard important?**

Bending strength and Internal Bond are the key engineered lifestyle properties of the particleboard which reflect like a healthy heart and a positive mindset in a human body. Poor properties mean premature death of the furniture.

**HeveaBoard**



### HeveaBoard Quality vs Competitors.

eg. Bending strength of  $>13\text{N/mm}^2$  vs  $10\text{N/mm}^2$ .

Internal Bond of  $>0.35\text{N}$  vs  $0.25\text{N}$ .

Thickness Swelling  $<5\%$  vs  $<8\%$

HEVEABOARD never compromises on quality and ensures the product at market prices at all times. It has dedication to uplift the falling standard of quality in the particleboard industry. All boards look same from outside to a furniture manufacturer and lack of the knowledge of cause and effects of the key properties on the life of furniture is rapidly earning a bad name for particleboard industry in India.



### What is Formaldehyde?

Formaldehyde is a common precursor to more complex compounds and materials. When treated with phenol, urea, or melamine, formaldehyde produces, respectively, hard thermoset phenol formaldehyde resin, urea formaldehyde resin, and melamine resin. These polymers are common permanent adhesives used in plywood, ParticleBoards and MDF. Production of formaldehyde resins accounts for more than half of formaldehyde consumption.



### Why is Formaldehyde hazardous to health?

Formaldehyde has been declared a known carcinogen chemical and for any indoor use the emission level is necessary to be below  $8\text{mg}/100\text{g}$  oven dry board.

### Why choose low emission Particleboard?

Low emission ensures the air quality has no toxic emissions from the furniture items. In India unfortunately the awareness of the formaldehyde emissions is too low. In EU all engineered board manufacturers have self imposed to produce only E1 norm as standard minimal emission and other countries too have similar or lower emission like E0 level board mandatory. HeveaBoard can supply upon request E0 as well as CARB P2 and F\*\*\*\* compliant particle boards.



HeveaBoard

**BEWARE!!** Do not fall prey to cheaper look alike boards which will fail in screw holding, load bearing and make you replace the furniture within few months. Laminated particleboards can be easily identified by HEVEABOARD stamp on edges. For Furniture buyers our channel partners can provide a certificate with shipment on the motherboard used.

**Issued in public interest for well informed buying decisions by the furniture industry.**

Insist on buying from our Channel Partners: Amazon Wood Pvt Ltd; Prism Laminates Pvt Ltd, Shell Laminates Pvt Ltd & Stylespa (Indian Furniture Products Ltd). **HeveaBoard** is looking to increase channel partners in India who share the quality commitment. For any information please contact : [nvaze@heveamart.com](mailto:nvaze@heveamart.com)

# ‘We can offer fresh options to India’

‘Because the Indian market is enormous, European equipment and machinery are setting up factories locally, where taxes and production costs are lower. Gradually European prices have narrowed in on those of Taiwan’



*Mr. Bae Hsy-tingsong is Chairman of the Taiwan Woodworking Manufacturers' Association. He spoke exclusively to WoodNews for this article.*

In recent decades the Taiwanese woodworking machinery industry has worked hard to establish many well-known brands in markets throughout the world. Among the early ones to enter the Indian market include Technik, Boark, Leadermac, Powermax and Holytek. These companies have gained acceptance and brand effectiveness in the Indian market, and earned the recognition of several buyers.

Currently the demand for doors and door frames is predominant in the Indian market. Manufacturers need machinery suitable for this area of production, and Taiwan's heavy equipment – such as 4-sided moulders, sanders, tenoners, CNC machining centres and painting equipment – are proving competitive options.

Analysis of the Indian consumer market reveals the following trend: well-funded manufacturers buy more of whole plant production lines from Germany and Italy. Small factories prefer to select inexpensive Chinese machinery or manufacturing equipment made locally in India.

Indian manufacturers who employ the use of Taiwan-made machinery applaud its durability and quality, but struggle with the pricing. China offers very low prices, but its production of heavy or specialized equipment hasn't earned a reputation for stability – which means that in this domain Taiwan can compete.

## **Smart Bargainers**

Because the Indian market is enormous, European equipment and machinery are setting up factories locally, where taxes and production costs are lower. Gradually European prices have narrowed in on those of Taiwan.

Between 2013 and April 2014, the value of Taiwan's exports to India rank the country merely at 14 among all of the countries Taiwan exports to.

Indian users are smart bargainers. They do not like to purchase through dealers and tend to go straight to the manufacturers. In the beginning, India's woodworking industry relied on imported machinery. But they have gradually learned to manufacture their own machinery, and they are

improving rapidly.

## **Wood Taiwan**

The main woodworking machinery exhibitions in Taiwan are Wood Taiwan, the international woodworking machinery show. It is set to make its debut (2-5 July, 2015) at the Taipei Nangang Exhibition Hall. It is being co-organized by TWMA and TAITRA with the theme 'Work green, Live better'. This exhibition is Taiwan's only professional woodworking machinery exhibition.

Not only will well-known Taiwan woodworking machinery makers display their latest research and development of new models, organizers are actively inviting foreign manufacturers (including China) to participate.

There will also be an 'Outstanding Product' competition and the first-ever pavilions for cross-strait woodworking machinery and whole plant demonstration. The event is sure to reveal some very exciting innovations, and I enthusiastically welcome the global community to come to the exhibition and procure.

**MACHINERY & SUPPLIES  
NEW DEVELOPMENTS**



Horizontal Mill



HTZ-800



Sliding Table Panel Saw

Spindle Moulder

Alfa NC Milling

Automatic N.C. Operated



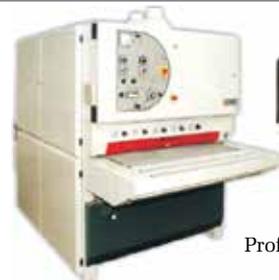
- Hinge recessing.
- Lock face plate recessing doors slots etc.

Louvers

**SANDING MAX**



Wide Belt Sander



Profile Sander

Segmented Pad



Multiple Rip Saw



Straight Line Rip Saw

Automatic Through Feed Edge Banding (Compact Machine)

Portable Edge Bander

Manual Edge Bander



Vertical Band Re-saw



Band Saw Blade Grinder

Three Head Multi Boring Machine

Hydraulic Hot Press 1/3/5 Day Light



Rectangular Tenoner DAD-115



Oscillation Mortiser MOM-130

Auto Panel Saw

High Speed Router

Spindle Moulder



Clamp Carrier

Heavy Duty Automatic Copy Shaper

Double Surface Planner



We Work Together



Jagadhri Road, Yamuna Nagar - 135 001 (Haryana) INDIA  
Tel.: +91 - (1732)-223694, 260682, Fax : + 91-(1732) 260203  
E-mail: kalyan1ind@yahoo.com, Website: www.kalyanindustries.in

# Barton presents innovation for log cutting



Barton has introduced to India one more innovation in the form of the DGB band saw. A machine for sawing logs of small diameter and re-sawing and edging of big slabs, planks and half moon shaped corners of logs, in short it is a universal machine.

When we talk about a DGB band saw, we talk about all the process of sawing in a single machine. It is made up of a vertical band saw, one movable table and rollers for output.

DGB band saw is a very effective machine in the Indian market, where a lot of sawmills are working on only teaks from Africa, from where almost all logs are coming in small diameters. In most cases saw millers are selling four-sided blocks of African teak. It can be integrated in a complete line for bigger diameter logs where re-sawing or edging of big slabs are required.

In the case of teak, saw millers look for quality. The material and design of this machine helps him to see the face of logs or slabs after cuts, because the movable table brings back the material in front of the operator from where he loaded the material to be sawn.

In other cases, logs of small diameter of pine can be sawn in this machine. One can make three faces of small logs and send them into another re-sawing machine of Barton for taking out the planks from them.



This machine can be used in jungle wood too, where the formation of logs does not allow getting a very long and big diameter log, so short length logs and small diameter of jungle wood logs can also be sawn in this machine.

## Processing

The operator fastens the logs, slabs or half-moon corner of logs on the table with the help of a mechanical device powered by pneumatic cylinders. Once the material is fastened onto the

table according to the cut to be given, the operator gives orders to the table to go forward towards the band saw blade via PLC for producing the cut.

The feeding speed of table is regulated. Reaching at the end after finishing the cut, the table separates its line automatically from the line of band saw blade and comes back at the point of loading the log, where the log will be released and will be positioned for the next cut.

In the area of loading the logs, we have one gauge for giving measurement which works with the help of a motor and one-touch screen PLC for giving each and every command to the machine like for giving measurements etc.

Vertical Band Saw DGB has a guide for stable cutting which works hydraulically, lubrication of band saw blade is automatic.

## Dimensional requirement for logs

Minimum cutting length: 600mm

Maximum cutting length: 4000mm

Minimum cutting diameter: 120mm

Maximum cutting diameter: 300mm

## Advantage

One can saw logs of small diameters in vertical band saw with the help of movable table where operator is working only as a feeder and does not push or pull the logs or big slabs, so accuracy of the wood can be obtained.

Skilled labor is not required, as machine is designed with such useful devices like laser light, log fastener, feeding speed regulatory system and of course movable table.

Barton has two vertical DGB bands saws working in India: one is in Nadiad (Gujarat) where the machine is cutting jungle wood logs of small diameter, and another in Chennai (Tamil Nadu) where it is re-sawing and edging big slabs of Burma teak and sawing teak logs of small diameter from Africa.

# Wood-Mizer enters wide-band market with WB2000



*Wood-Mizer's new wide band sawmill offers 6-tonne log capacity and a massive 900-mm throat opening.*

The WB2000 sawmill is the first in a new wide-band series that will be offered by Wood-Mizer to meet the needs of industrial timber producers around the world.

Running a 90-mm-wide band blade, offering maximum log capacity of up to 6 tonnes, and able to cut a 900-mm log in half, the Wood-Mizer WB2000 advances Wood-Mizer's industrial sawmilling range into new territory.

Designed as a high-production sawmill for the most demanding sawing conditions, Wood-Mizer's new WB2000 features heavy-duty construction, low maintenance

requirements, and efficient operation.

The twin post sawmill head can cut a 900-mm log in half, making it an attractive solution for managing medium to large logs. A 22-kW electric motor is standard, and a 30-kW motor is optional.

#### **Ease of use**

Computer seatwork and a raised operator control station allow a single operator to manage all sawing and log handling functions while maintaining a clear view of his work.

The WB2000 features a 19-cm HMI touch-screen which presents all important information to the Sawyer. Board and cant sizes are

displayed, along with current head height, feed position and blade power.

One of the popular functions is the Auto-Cut feature, which remembers the location of the start and end of the log and prevents the saw head from overshooting either end. As a result, the sawmill spends more time sawing.

The new deluxe joysticks provide the operator with precise control of all sawing and log handling functions, and feature proportional hydraulic speed control.

The bed is heavily constructed to handle logs of up to 6 tonnes. The



A single operator controls all sawmilling functions from a raised station with joysticks and advanced computer controls.



Four cameras mounted on the saw head stream live video back to the operator, giving him a clear view of hard-to-see areas.



The WB2000 features hydraulic log handling functions for clamping, turning and offloading logs and cants.

twin C-channel steel beams that make up the frame are massive – 400-mm tall by 110-mm wide.

#### Complete Solution

All hydraulic log handling functions – such as the log clamps, chain turners, and power rollers – are modular, and can be moved to different bunks as needed. Wood-Mizer also supplies a complete line of conveyors, tables, and material handling equipment to accompany the WB2000.

Wood-Mizer worked in cooperation with Zenz Landtechnik GmbH, a highly respected German wide band sawmill manufacturer with a 150-year company history, in order to offer a product that will feature the best that modern sawing technology has to offer.

To support expanding the product range into larger machinery, Wood-Mizer completed construction of an additional

production hall in early 2014. “We want to be a provider of sawmilling equipment to the timber industry at all levels,” says President and CEO, Mr. Richard Vivers.

“We have diversified our geographical presence and our products. The expansion of our European headquarters gives us a solid base to move up to the next stage in the sawmilling industry globally,” he adds.

## Altendorf adds a saw unit tilting in both directions

With a saw unit that can be tilted in either direction, the Altendorf F45 Elmo-III-D offers even greater flexibility for sawing bevels and compound mitres. The operator can choose whether to position the work piece against the rip fence or cross cut fence.

Such a saw unit offers a number of benefits:

- a) Bulky/ heavy work pieces can be cut without awkward manipulation as the saw blade tilts relative to the work piece
- b) Work pieces with delicate surfaces can be processed

on the sliding table with the external (good) side uppermost, for even cleaner cutting

- c) Tilting in either direction enables matching angles to be cut precisely and efficiently.

In addition the F45 Elmo-III-D features a motorised rip fence and eye-level control panel. Because of these features the following advantages are achieved:

- a) Accuracy up to 0.1mm or rip fence setting dimension
- b) Increased productivity because



the operator does not manually set the fence

- c) Reduction of labour. Additional options are available for special cutting needs. With this new development, the best just got better.

# Masonite Gold launched in India



Test specimen of 'Masonite Gold' (L) and a competing look-alike (R) show up the winner after 4 hours of boiling. There is no fibre disintegration and minimal caliper change from the original in the case of the Masonite sample.

In keeping with Masonite's commitment to the Indian door manufacturing industry, it has launched a new brand identification policy to differentiate its premium products from the non-conforming competition

India's largest-selling door skin brand also provides the assurance to consumers that its premium products meet the requirements established by the Bureau of India Standards (IS-15380:2003). Its new brand, Masonite Gold, is fortified with phenolic resin for superior moisture resistance, and is the only molded skin that can survive the 4-hour boil test without fibre disintegration.

Manufactured from 100% re-claimed hardwood residue, it is environment-friendly and is resistant to fungus & mildew. It has the highest density among all door skin products and is resistant to breakage and damage. Each Masonite Gold door skin is factory-primed in a golden shade colour.

According to Mr. Greg Wysock, Masonite's Technical Sales & Product



Mr. Greg Wysock, Masonite's Technical Sales & Product Manager for Asia-Pacific.

Manager for Asia-Pacific, there has been a "remarkable" market share growth of interior molded doors: from less than 3% of the market a decade ago to 20% now. "The perception of an interior molded door was extremely doubtful... That such a door (produced using 3D molded wood fiber door skins) could ever perform to India's standards and would ever be widely accepted."

However, Greg warns that the success of Masonite's molded door skin products in India has spawned competing look-alike products, rather than competitive substitutes. "Masonite is not afraid of competition; in fact we welcome it. Serious companies will produce better products, thus benefitting the consumer."

What disturbs him is when the substitute products steal market share with products that are inferior, that do not meet industry standards established by the authorities. "Consumers are unaware that perhaps their interior molded door is manufactured using non-Masonite door skins that do not meet the requirements established by the Bureau of India Standards," he contends.

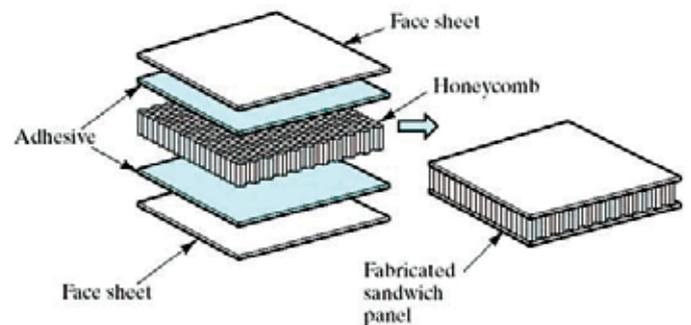
*Masonite operates the world's largest, private research & development facilities in the industry, to provide support in new technologies and materials for use in current and future products. (www.masonite.com).*

# Aquence series for moulded panels and flush doors

Moulded panel doors are prefabricated ones, made to fit various applications and operational requirements. Their design structure usually varies with the application area and might use several different materials.

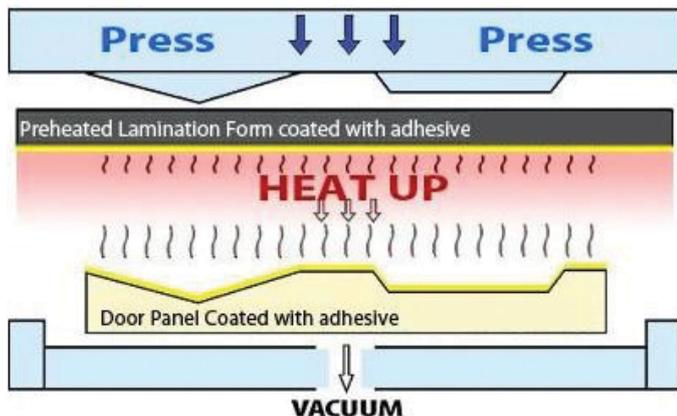
Depending on the application area, superior quality adhesives have to be used to ensure optimal shelf life, and meet operational parameters.

The Aquence product range from the house of Henkel is a ground-breaking innovative and sustainable water-based adhesive solution for the most pressing challenges. It has the full range of water-based technologies which includes water-based acrylics, colloids, PU dispersions, PVAC and VAE dispersions.



based primer and anti-metal mark coating, after the pressing process. The anti-metal mark coating is applied to keep the surface clean during the whole manufacturing process. The doors are then cut into required size. Independent door manufacturers then make interior moulded doors from the door panels.

Henkel Adhesive solutions for moulded and flush doors are very user-friendly and convenient to apply to the surface and easy to clean. They can be applied to the surface by spraying, brush as well as by mechanical glue spreaders. The open time can be modified according to the application; so there can be provision for long or short open time.

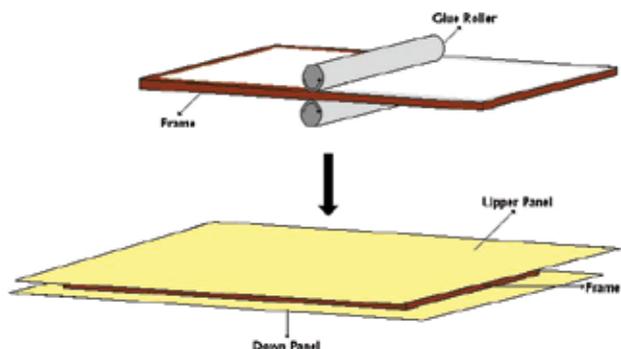


Aquence solutions will enable furniture manufacturers to improve their total cost of ownership and product quality for consumer products. Henkel offers international grade adhesives for moulded panel and flush door:

- Aquence MD 161 (meets EN 204/205 D2 standard)
- Aquence KL 472 FF (meets EN 204/205 D3 standard)
- Aquence SL 463 (meets EN 204/205 D4 standard)

## Process

The door panels can be fabricated with a smooth or grained surface. They are primed with a water



These D3 and D4 water-resistant adhesives maintain dimensional stability: no warping, twisting and cupping of the molds, no chance of blister formation and hence no rejection. The adhesives are free from hazardous formaldehyde, are non-toxic and non-flammable, and are ideal for cold and hot pressing. The dried adhesive film is non-brittle, with soft and resistant glue line and transparent adhesive film.



# PANEL PROCESSING MACHINES



BHOGGAL +91 98883 99880

## WOODMASTER (INDIA) MACHINES PVT.LTD.

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# ‘Wide’ choice of particle board presses



## Production line for the manufacture of wood-based panels with continuous press technology, designed and manufactured by China Foma (Group)

The continuous press, with a pressing width of 8 feet, is a newly-developed product from China Foma. The key technologies in continuous press, are flexible feeding head, self-correction of board thickness and shape, online monitoring of steel belt and roller rod, etc. These are effectively integrated in the design.

China Foma has formed multiple intellectual properties of its own, including innovation patent granted by a European patent organization. The production line for the manufacture of MDF/HDF, with a daily capacity of 1,000 cubic metres, has just been installed and is now under commissioning in Nanning, Guangxi Province, China.

### Technical characteristics

- Flexible feeding head precisely controlled by oil cylinder and mechanical lifter

- Long distance for high pressure segment benefiting process adjustment
- Short jointing of neighbouring heating platen and specially designed thermal oil channel inside the heating platen achieves minimum heat loss
- Flexible moving design of the frame due to heat expansion
- Servo-control technology from Siemens (Germany) is adapted in controlling moving parts of the press
- Proportional valve is highly adapted in position control of the press
- Widely applied Europe-based electric and hydraulic components, such as SEW gear reducer, Schneider sensor, Rexroth hydraulic pumps and Moog proportional valve, etc.

The continuous press is mainly

composed of steel belt and transmission assembly, roller rod assembly, frame and heating platen assembly, hydraulic system, thermal oil circulation system, electric control and automation system, thermal insulation system, lubrication system, cleaning system, integrated structure, etc. Special tools are also supplied to facilitate the installation of the equipment.

At a time when continuous presses have been monopolized by European suppliers, standalone machines supplied by China Foma – such as drum chipper, knife-ring flaker, refiner, sanding machine for calibration and finishing, polishing machine, cut-to-size line, etc. – are now widely integrated in the production line with continuous press technology. These quality machines have already proved to be the best choice of mainstream wood-based panel manufacturers in China.

To better cater to the precision





Technical parameters			
Size Specification	6 feet	8 feet	9 feet
Pressing speed (mm/s)	60-1200	60-1200	60-1200
Operating height (mm)	1500	1500	1500
Heating platen width (mm)	2050	2650	2950
Main driven roller dia. (mm)	Φ2070	Φ2070	Φ2070
Main driving roller dia. (mm)	Φ2100	Φ2100	Φ2100
Roller rod Dia. (mm)	Φ20	Φ20	Φ20
Steel belt thickness (mm)	2.7	2.7	2.7
Steel belt width (mm)	2070	2670	3030
Max. specific pressure (MPa)	5	5	5
Pressure segment	4	4	4
Effective pressing length	Decided by capacity and pressing factor		
Power installation	To be confirmed after engineering		

requirement of continuous press with wide width (more than 6 feet), China Foma has developed the machine based on its accumulated mature technology and rich experience, such as forming machine, continuous pre-press with longer pressing segment, mobile loading conveyor, high-speed diagonal saw, intermediate storage system, cut-to-size line, etc.

China Foma has already developed and formed its capability to supply complete machinery for the production of particle board, OSB, MDF/HDF, etc. with continuous press technology. This brings more choice to customers demanding quality machines as well as investment efficiency.

## ICA develops high-performance, high-aesthetics coatings for wooden frames and shutters

The pressure is on manufacturers of wooden frames and shutters to come up with tangible innovations in order to make an impact on a market in which the range of wood alternatives on offer is growing year-by-year.

This requirement has led the ICA laboratories to develop an all-new system of water-based colours and effects that have been specifically designed for wooden door frames, window frames and shutters.

In terms of the aesthetic aspect of the finish, in the frames and shutters sector, there is an ever-increasing requirement to stay in step with the latest trends in interior design – above all because windows are now considered to be an integral part of the overall scheme.

This challenge provided the stimulus for a typically creative ICA solution: the aim was to maximize the protective action by developing unique colours and proposing attractive combinations for the internal part



*The water-based colours deliver two-tone effect on wooden frames.*

of the frame or shutter and the external part, which is of course the part exposed to atmospheric agents.

The development by the ICA R&D laboratories of this innovative colour system for wooden frames and shutters was carried out on various traditional wood species and on Accoya.

### Two-tone Effect

The brand-new 'natural' colours of the Arborea Natural Matter water-based impregnating agents and the wide range of pastel shades of the Arborea Pastel water-based impregnating agents, together with the Arborea Metal line of water-based metallic top coats and the classic water-based lacquered top coats, collectively compose the combination system designed by ICA to allow for the creation of two-tone effects on wooden windows.

These tone-on-tone, or contrasting combinations, make it possible for the internal part of the window to be aligned with the nuances of the interior design scheme, while the external part ensures a level of durability of the wood that is comparable, if not indeed superior, to that of other materials.



ICA analyzed the durability of its coating cycles on various wood species, including Accoya. This type of wood is subject to a chemical process (acetylation), which modifies its structure, thus influencing its physical and mechanical characteristics.

This process is not a treatment – rather, it is a cellular modification of the wood, which significantly increases its dimensional stability and durability, without releasing any toxic chemicals into the air or into the ground.

The particular features of Accoya, in terms of the exterior durability of the coating film – as confirmed by the stringent tests carried out by ICA and by specialist external laboratories – make it suitable for the construction of windows and in particular of shutters, which are subject to a great deal of contact with atmospheric agents.

In both cases, the use of the ICA colour system makes it possible to achieve an infinite number of aesthetic/chromatic combinations.

### Cleaning Simplified

Cleaning and refreshing operations have also been simplified and reduced to a minimum, thanks to specific products such as ICA's Easy Coat, a water-based conditioner for the ordinary cleaning of frames and shutters, which prevents the degradation of the coating film and maintains intact the natural beauty of the wood.

In this way, wooden frames and shutters can regain their prominence in all of those markets where there is a twin focus on both the look and the quality of the product. The use of new, durable wood species such as Accoya, in combination with customized coating cycles, allows manufacturers of frames and shutters to offer even longer guarantees on durability.

*ICA Group, based in the central Italian city of Civitanova Marche, is a leading European name in the manufacture and marketing of special coatings for wood. In 2013, it posted a turnover of*



ICA analyzed the durability of its coating cycles on various wood species, including doors made of Accoya.

€104 million, 40% of which was generated through export markets. (www.icaspa.com).

## TrueCoat Pro-X cordless sprayer

The TrueCoat Pro Fine Finish cordless sprayer from Graco is designed specifically for small, fine-finish projects. This sprayer features a ProControl pressure control system that allows the user to optimize the pressure setting for spraying a full range of fine finish materials – from stains to lacquers to enamels.

Innovative design features make this a unique sprayer that is fully compatible with solvent-based materials, including hot solvents.

### Benefits

- Small, compact design is ideal for fine-finish applications
- ProControl system allows independent adjustment of pressure, flow rate
- Patented ProSpray technology compares with professional airless sprayers
- Spray material as designed by the paint manufacturer; no thinning required



- Consistent, even spray pattern for one-pass coverage

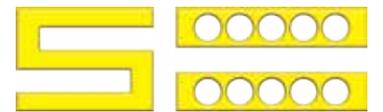
The patented ProSpray piston pump technology gets the user ready to spray in seconds! It affords the ultimate portability to move around on the job and gives professional quality finish.





© Calotte - Fotolia.com

# Thick is beautiful!



Sauerland Spanplatte

**Change over to 40/44 mm thick doors.  
Say goodbye to 30/32mm doors.**

Now Sauerland launches a specially engineered door infill which enables door manufacturers to cater to the builders and architectural requirements at a incremental cost increase. A win-win-situation now unfolds.

The tubular infill boards are **ecofriendly and green product initiative** replacing the 80% of timber used internally as door infill which dramatically improves the performance of the door.

- **with ideal weight:** About 50% weight reduction
- **resisting daily stress:** No damage under workload
- **Production with high efficiency:** Low operating costs
- **that close properly:** No bending
- **with a perfect surface:** Thickness precision +/- 0,1 mm
- **reducing sound transmission:** Less noise pollution
- **protecting from fire:** Fire protection



**50%  
thicker doors  
at just 20% more**



Solutions for the better door!

Sauerland launches a 34/38 mm tubular board which will be the heart of the 40/44 mm door with 3 mm skin both sides. These European thickness doors are available from all leading door manufactures. Contact us for details to know the supplier closest to your construction site at [sleekboards@gmail.com](mailto:sleekboards@gmail.com)



The transparent 0.75-litre paint cup with adjustable suction tube enables spraying in any direction, floors, ceiling and walls. Disposable cup liners for fast and easy clean-up

includes a cover for paint storage or quick-shake cleaning.

The unit includes the TrueCoat Pro cordless airless sprayer, 210 & 312 fine-finish reversible tips, two 18V

Lithium-ion power pack batteries & charger, a 700-ml multi-spray cup with cover and five disposable cup liners, a bottle pump armour and cordless sprayer storage case.

## Spray-finish with a paper roll, without masking

For easy access to the work piece, the Speed 20/10 spray table can be rotated by 180°.



How often do you have demanding finishing jobs that require time-consuming and expensive masking and cleaning work? Do you really want overspray to destroy the results of your finished work pieces? Finish departments can master this challenge by laying and transporting the work piece on paper without masking.

At the Holz-Handwerk trade fair in Nuremberg (Germany), Martin presented the innovative Speed 20/10 spray table for the first time. You may see that the idea for the Speed 20/10 is not really

a new one; but there has been no convincing solution on the market until now.

In order to mask, the work piece's bottom side is simply placed on the paper layer on the table top. For easy removal of the finished work piece from the coating table, it is pneumatically lifted. The paper is moved over statically neutral plastic rollers.

After every finishing job, a new and clean paper surface can be produced within seconds. For easy access to the work piece, the table can be rotated by 180°

during spraying.

The lifting components and the feed of the paper roll are controlled by foot switches. The table is operated completely without an electrical power supply; the movement of the paper is done pneumatically. This ensures a safe use of the table also in explosive environments.

The paper roll can be changed easily without tools and a brake



The paper roll can be changed easily, without tools, and a brake prevents the roll from unwinding itself.

### Technical Data

Work surface length	mm	approx. 1800
Work surface width	mm	approx. 1000
Work plane height	mm	approx. 750
Paper roll width	mm	approx. 1000
Paper weight	g/m <sup>2</sup>	70 - 200
Weight	kg	200
Compressed air connection 3/8 quick plug	bar	6
ATEX-Zone	II 3G	





prevents the roll from unwinding itself and helps to keep it tight. The Speed 20/10 spray table clearly eliminates unnecessary work.

There is a considerable saving

potential for paint shops since the preparation and finishing aspects of the job are reduced to a minimum. This combination of user-focus, technical know-how and solid machine construction

provides the operator with a powerful solution.

*To see how the Martin Speed 20/10 spray table clearly eliminates unnecessary work, watch the video on [www.woodnews.in](http://www.woodnews.in).*

## Oikos: hi-tech solution for joineries



 Area is a dedicated gantry-based solution with automatic 5-sided machining for large-size and laminated insulating panels.

In recent years Routhtech at SCM Group has been offering various applications in the timber construction segment and has developed new machining concepts that offer users flexibility, precision and 6-sided complete machining.

The latest system versions enable users to carry out complete machining operations for roofs, wall elements, garden sheds, pergolas, X-LAM/CLT glulam structures, straight, curved and rounded trusses, one-off pieces, roof insulating panels and any type of new structural elements requested by the market.

The success of Routhtech's solutions is confirmed by the growing number of installations

worldwide, with 30 systems up-to-date, of which 25 are Oikos. Oikos is a high-tech solution for modern joineries that are ready to invest in new machinery. It is an advanced solution that supports the widest range of machining operations, both for beams and wall elements, with maximum length of up to 1,250 mm, maximum thickness of 300 mm and variable length.

Its main characteristic is the fact that it is equipped with an automatic 6-axis CNC system, complete with tool changer, and a single machining head, which guarantees a simple, rational and extremely flexible layout.

Area is a dedicated gantry-based solution for X-LAM-CLT wall



 The Oikos' single machining head guarantees simple and extremely flexible layout.

elements and basically large-size components for automatic 5-sided machining, such as large glulam beams. It can be customised to carry out machining operations also on large-size and laminated insulating panels.

Area is also fitted with an automated 5-axis machining head and a tool changer. Machining dimensions vary from 3,200 mm to 4,500 mm width, with thickness of up to 360 mm and length of up to 50 metres.

Oikos and Area's machining areas are fully enclosed and equipped with safety devices for the operator's comfort. These products were showcased (4-7 Sept.) at Holzmesse in Klagenfurt, Austria. ([www.scmgroup.com](http://www.scmgroup.com))

## Easy application from Tece

When Tece Decor develops its portfolio of products, it not only considers the big producers of furniture, but also take into consideration those that can cover the edges without investing huge amounts of money in machinery.

Keeping this in mind, it offers pre-glued edge banding in PVC, melamine and veneer. This way, Tece serves smaller customers and helps its intermediary distributors to supply edge banding to anyone, from big to small producers.

Pre-glued edge banding is coated with hotmelt adhesive on the back side, which is activated by heat of minimum of 130°C. It can be activated with standard iron or hot air blower.

Correct application of pre-glued edge banding can produce excellent adhesive, as if done with machines!

No matter which self-adhesive tape is used on the back of the edge banding,

there is the possibility of having the band peel off from the panel's edge. Yet, with hotmelt-backed edge banding, one can decrease this risk to a minimum.

The pre-glued PVC edge bands are available in thickness of 0.4mm for iron application. The thickness can go as high as 0.8mm. Above 0.4mm, hot air blower must be used, because an iron cannot melt the glue due to the thickness of the product.

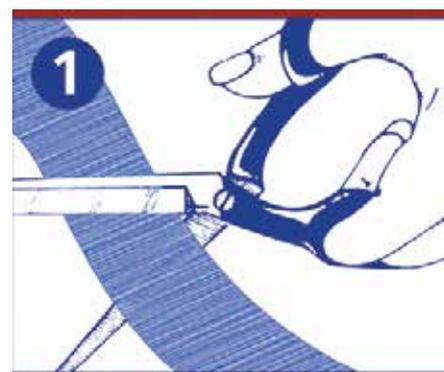
At Tece, we can supply our complete range with hot melt pre-coating. The width of pre-glued edge banding can change between 16mm and 120mm, depending on the demand.

Tece Decor offers the following products:

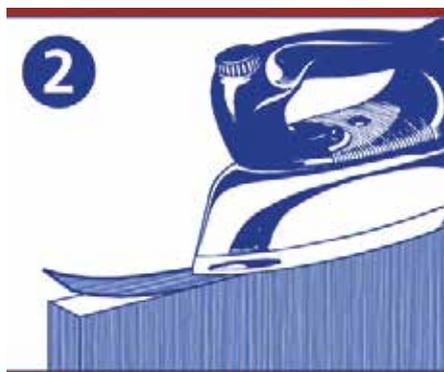
- Pre-glued PVC edge banding: Any thickness between 0.4mm and 0.8mm is possible to have the hotmelt pre-coating.
- Pre-glued melamine edge banding:

This is the most common and least expensive hotmelt pre-coated edge banding.

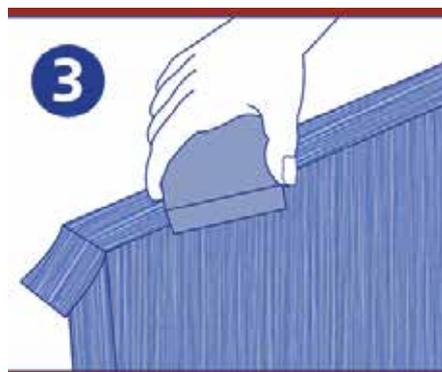
- Pre-glued veneer edge banding: This can easily be applied with iron or hot air blower.



*Cut the edge banding 3 cm longer than surface to be covered. Make sure the surface is dust-free, clean and dry. Also check to see there are no rough spots on the surface.*



*Put a Teflon protector under the iron to avoid melting the PVC edge banding. Adjust the iron to cotton temperature. Apply the edge banding with hot iron or hot air blower as described.*



*While still hot, press firmly with a wood block to the board.*



*Allow the edge banding to cool completely, remove the extra edges with a trimmer or a razor blade.*

# Fevicol Adhesive Solutions for Woodworking Applications



## Fevicol Hotmelt Products

Fevicol's range of edge banding adhesives has several options for manual as well as automatic machine application. All options provide good adhesion properties with good resistance against heat, cold, moisture and oxidation.

Hotmelt 380 (unfilled) and Hotmelt 388 (filled) are Ethylene Vinyl Acetate (EVA) based thermoplastic adhesives recommended for through feed edge banders. They can be used with PVC, PP, ABS, veneer, polyester or melamine resin edge bands.

Hotmelt 382 is specially designed for manual edge banding machines. It can be used to apply PVC, HPL, ABS or solid wood lipping onto MDF or particle board.



## Fevicol SWR Range

Specially designed for the handicraft industry, this Polyvinyl Acetate based white adhesive meets the DIN EN 204 Stress Group D3 Standard. It is suitable for all types of wood working applications and provides very high water resistance and excellent bonding in lamination with all grades of wood, even in high humidity areas. Fevicol SWR Plus is specially designed for application in cold weather conditions. SWR EQ has even better cold weather performance and can achieve D4 standard by adding 5% isocyanate. SWR LV has very low viscosity. All are non-flammable and non-toxic with REACH Compliance, Low VOC (Volatile Organic Compound) Certification and Free Formaldehyde Certification.

## Fevicol PVC Fix

This water/synthetic resin based emulsion adhesive is suitable for lamination of primer coated PVC sheet to MDF. It is also used for manual edge banding of primer coated PVC Strip to MDF, particleboard, ply etc without using any edgbanding machine, making it highly economical. It has excellent bonding compared to solvent based adhesives, as well as high heat resistance, easy applicability and low VOC



## Fevicol SH

The classic PVC white glue for wood to wood bonding features unsurpassed bonding strength, good resistance to water and heat, higher coverage and good value for money. It is not only a leading brand in India, but also the most successful brand in the world in this segment, being exported to over 50 countries.



## Fevicol SP Range

This range of sprayable, synthetic rubber based solvent borne contact adhesives can permanently bond painted steel, plywood, chipboard, PU foam, muslin, foam rubber, felt, fabric, leather or many other materials. SP-4 is the basic version. SP-5 is specially designed for the automotive industry and is also used to make writing boards using honeycomb cardboard and white laminates. SP-6 also has high heat resistance.

## Membrane Press Range

Fevicol Membrane PU is a solvent based polyurethane contact adhesive used to bond PVC foil to MDF, plywood or other materials. It is ideal for door manufacturing, with low activation temperature, fast drying time and good bond strength.



Fevicol Membrane Press Star 2K is a two-component water based synthetic adhesive used to bond PVC film laminate to wood based panels in the modular furniture, modular kitchen and doors industries. It has excellent heat resistance, low activation temperature and high green tack. It is non toxic and non flammable.

## Fevicol Heatx

Fevicol Heatx is a synthetic solvent-borne rubber-based adhesive made with a special formula with excellent heat resistance of up to 170 degrees Celsius. It also possesses quick grab property and strong bonding efficiency. It comes in 1 litre and 5 litre packing.



It is used in bonding challenging substrates like PVC foam sheet, WPVC, UPVC sheet to Mica, PVC film and veneer.

However, some precautionary measures have been recommended by the manufacturer:

- Bonding surface has to be sanded using No. 80 ambar paper or any handy sanding machine
- After cleaning the surface, Fevicol Heatx should be spread in one direction only
- Wait for 7 minutes to remove solvent for the adhesive system
- After joining both substrates, apply pressure using hammer strokes on wooden patti for strong contact
- Remove excess mica or PVC film using knife or trimmer after 5 minutes
- Initial bonding takes 3 hours; final bonding strength comes after 24 hours
- The same process can be used in roller press machines for faster production

# What I've always wanted...

AHEC announces its participation at the London Design Festival 2014 in collaboration with the UK's Benchmark Furniture



Pic: Petr Krecji

*'Wish List' commissioners and designers.*

Berkshire workshops since early July. Among them are a "perfect" pencil sharpener, an extendable fruit or cheese bowl, a triangle shelf, slanted door & a hook, kitchen stools and tableware, a garden shed, a ladder and a chaise longue.

The project builds on the American Hardwood Export Council's (AHEC) prior initiatives, which have promoted American hardwoods. Its association has resulted in a series of innovative installations, including the Sclera Pavilion, the Timber Wave, the Endless Stair and the Out of The Woods exhibition in recent years, according to Mr. Roderick Wiles, AHEC Director for Africa, Middle East, South Asia and Oceania.

During the manufacturing process, the teams will record all material inputs and energy consumption, allowing them to assess the environmental impact for each object, using data from AHEC's life cycle assessment (LCA) research for 19 American hardwood species. The LCA is a scientific tool that helps industry to establish environmental frameworks that have real meaning and assess true sustainability.

The result will present the cradle-to-grave impact of creating each product across six categories. The most topical impact category is global warming potential, or carbon footprint.

AHEC has also developed a microsite for 'The Wish List' project, which is now live at [www.wishlistldf.info](http://www.wishlistldf.info)

"What have you always wanted in your home, but never been able to find?"

That was the question posed to a clutch of leading European architects and designers by Mr. Terrence Conran. The co-founder of Benchmark, a 30-year-old leading British company of craftspeople and designers, works extensively with hotels, restaurants, public buildings, offices and private residences.

The architects and designers will collaborate to create a compelling installation, 'The Wish List', which will be exhibited at the Victoria & Albert Museum during this year's London Design Festival, which runs from 13-21 September.

Such an open brief guarantees an extraordinary spread of design and the challenge is to produce each project in

a single material – American hardwood – in celebration of the versatility of timber and the enormous variety that can be achieved with it.

Some of the most illustrious names in architecture and design – Paul Smith, Norman Foster, Amanda Levete, John Pawson, Alison Brooks, Zaha Hadid, Alex de Rijke, Richard & Ab Rogers, and Allen Jones – have all indicated what product they long for.

Says Mr. Sean Sutcliffe, co-founder of Benchmark, "The diversity of the pieces will be a terrific platform for learning, enriched by the interaction of so much design and making talent. In our workshop of over 50 skilled craftsmen, we're confident that we shall see 10 fabulous results."

All of the items are being crafted in American hardwood at Benchmark's



# Hafele presents 'Beauty Areas' by Webert

When beauty is around you, you are naturally inspired to imbibe it! Hafele has coined the term 'beauty area' to that part of your customers' bathroom that takes care of their day-to-day beauty and hygiene needs.

The pioneering range of 'Beauty Areas' from Weber, Italy, have specially been created to give discerning clients a blend of practicality with comfort and beauty. This foundation is backed with a quest of bringing in new designs from leading international trends.

Deviating from the norm, our Beauty Area wash basins are made of mineral Marmo, a highly durable material comprising of precious mineral charges and polyester resin. This unique material gives inherent warmth to the



wash basin surface, in contrast to the cold harshness of ceramic.

The Greta lines and stable shapes create a place dedicated to beauty, thanks to its harmonious shapes and purity of design, combined with the ease to carry out day-to-day grooming and cleaning activities.

Greta is an innovative product that allows for detaching the basin from its base without any tools, leaving the wide top free to allow for easy cleaning.

The sinuosity of lines and lightness in shapes make Angelica a collection naturally unique. Simple and functional at the same time, its organic shape adds a sense of fluidity to the dynamic bathroom environment.

# The Beat-Shelf: Icon of Life

What about the Beat-Shelf, you might wonder? At first glance, this bookshelf is quite an eye-catcher due to its iconic shape. But let's not overlook the use of materials, as well as the utility of the design.

In the slits you can place magazines and books. On the top of the spikes you could place the book you are currently reading, without losing sight of where you stopped. And, because of the sides, you do not even need bookends!

The idea behind the Beat-Shelf relies on a question the Dutch duo of Van Tjalle and Jasper challenged themselves to answer: "What could be the most iconic sign that represents life? What could really express the meaning of life?"



They came to the conclusion that the most universal sign of life must be a heartbeat line, the starting point of the design process, which then led to

the creation of Beat-Shelf. The result is a bookshelf that sometimes attracts more attention for itself than the things you would put on it.

The Beat-Shelf comes to life in rough solid wood, be it American walnut, olive ash or European oak. Due to the specificity of the cuts that are needed to make the pieces, Tjalle & Jasper have built some tools that enable them to cut the wood vertically. The Beat-Shelf is designed and created in their workshop in Amsterdam.

Dimensions: 120cm x 30cm x 55cm.  
Weight: 12 kg.

While Tjalle is an industrial designer, Jasper has been working as a woodcraftsman for some years now. In 2012 they decided to start designing together under the name Van Tjalle en Jasper, which has been quite successful so far. (<http://van-tjalle-en-jasper.nl/>)



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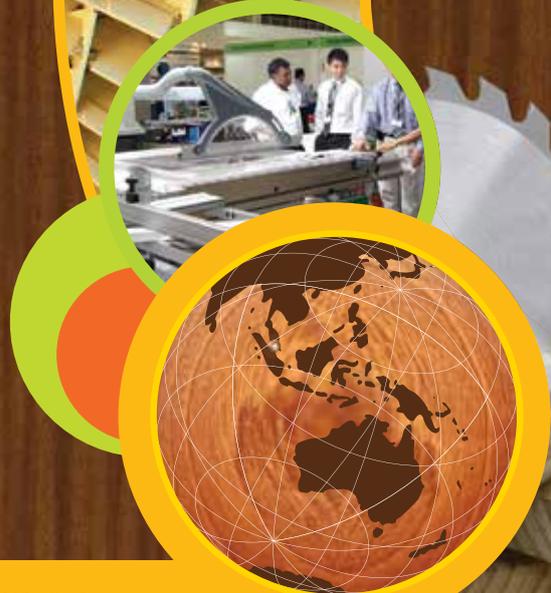
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WOODNEWS

# Intermob poised to surpass its own record



The year will be a milestone for Wood Processing Machinery & Intermob fairs, which bring together the leading companies of Turkey and the world in the field of forestry products and furniture side industry.

Extending up to 1,20,000 square metres exhibition area in two new halls, the fairs will be held with the highest level of participation from September 27 to October 1, at the Tuyap Fair Convention and Congress Center, Buyukcekmece, Istanbul.

Considering the economic fluctuations in the market, the fairs are arguably the most important fairs of the sector in Eurasia and have grown steadily for 27 years. Organized with the attendance of 880 companies and company representatives from 30 countries, it will have a total of 14 halls.

Beside the exhibitors attending the fairs with a larger space, the come-

back of leading companies in 2014 will put a new face to the fairs. Roma Plastik, Kapsan, Tem Aksesuar and Kent-Viole (furniture and accessories), Sar Profil and SFC (wood and forestry products), DYO (woodwork paints), Bosch (machinery and hand tools) and Özcanlar (door handles and accessories) will take part in the fairs.

## **Upholstery fabrics**

In 2014, the attendance of companies operating in upholstery fabrics industry will also lend colour to the fairs. The leading producers of upholstery fabrics, accessories, quilting and fabrics-cutting machines - among them Bekaert, Kisbu, Furniçin, Glengo, İlke Sünger, Güven Vida, Bols, Erike and Tetaş Tekstil - will exhibit their latest products in the fairs.

The fairs will bring again a wide range of products including forestry products, furniture accessories, seating groups and bed manufacturing

materials.

With the the attendance of around 1,000 companies from more than 30 countries, the fairs will be again the first address of innovation and latest technologies for industry professionals in Eurasia. It is expected the fairs will play host to more than 65,000 visitors from 90 countries.

During the fairs, qualified visitors consisting of 75% decision-making professionals, will also meet to take the opportunity of observing latest technologies.

With their 1.5 billion population and developing economies the Balkans, Caucasus, West Asia, North Africa and Black Sea Basin are very important markets for wood and furniture industry in Turkey that has an export capacity of US\$ 1.9 billion.

Through the marketing activities running also in foreign offices of Tuyap located in Moscow, Skopje, Cairo, Tehran, Sofia and Tbilisi; it is aimed for the exhibitors to take more market shares from these regions.

The Turkish Ministry of Economy will provide support to industry professionals from 52 countries: Albania, Algeria, Austria, Azerbaijan, Belarus, Belgium, Bosnia Herzegovina, Bulgaria, Canada, the Czech Republic, Croatia, Denmark, England, Estonia, Finland, France, Germany, Georgia, Greece, Holland, Hungary, Indonesia, Iran, Ireland, Israel, Italy, Kazakhstan, Kyrgyzstan, Kuwait, Latvia, Libya, Lithuania, Macedonia, Mongolia, Moldova, Morocco, Norway, Qatar, Poland, Portugal, Romania, Russia, Serbia, Slovakia, South Africa, Spain, Sweden, Tunisia, Turkmenistan, Ukraine, the UAE and Uzbekistan.

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## 26th edition ropes in hospitality industry

### Special Focus

Delhi Designers @Index 2014

- Sita Nanda (Hacienda)
- Ashish Anand (Living Spaces)
- Nitin Kohli (Furncraft De' Collage)

Commemorating the 26th edition of India's largest B2B interiors tradeshow, Index 2014 welcomes a striking array of suppliers from distinct segments: furniture, furnishings, decorative lighting and artefacts; kitchen and appliances; office and contract furniture and fixtures; intermediates for interiors such as flooring, doors, shutters, laminates, paints, architectural and building materials; architectural hardware, spanning an impressive 3,00,000 square feet of exhibition area.

Over the years Index Fairs has clung tenaciously to its guiding principle of being a focused B2B event, with a clear focus to the architect, designer and builder communities, and overall goal of creating a true platform for the industry, promising to wow the industry with its signature "business + design" initiatives.

Always a key feature of the Index Fairs

is the large array of international products, the 2014 edition (9-12 October) is the proud host to companies from Italy, Spain, Portugal, Turkey, the United Kingdom, Malaysia, China, Taiwan and the United Arab Emirates.

Index 2014 presents its visitors with the opportunity to network with delegates from various national



pavilions. This includes the UK pavilion hosted by British Contract Furnishing Association (Residential and Contract Furniture Group); Italian Furniture Group, furniture pavilion from the Association of Wood and Furniture Industries of Portugal; the Malaysian Timber Council incorporating several leading Malaysian brands and companies under the leadership of Taiwan Furniture Manufacturers Association.

In line with the Index vision of

providing an integrated platform for interiors and design, UBM Index Fairs has announced a long-term collaboration with Aura Art Development Pvt. Ltd., to host the Art Enclave at Index 2014.

Featuring the works (paintings, sculptures and photographs) of upcoming and celebrated artists and civil solutions (framing, glass casing, restoration, insurance) relevant to the art industry, the foundation of this art-focused initiative is to showcase the best of Indian and international art and provide an opportunity to connect with the architect, builder, designer and hospitality communities.

Invitation to this stand is open to art galleries, artists (painters/ sculptors/ photographers) and designers alike.

In keeping with the Index reputation of creating strong events to create meaningful industry interactions, Index Fairs hosts events for the kitchen industry with the successful 'Cooking up a Storm', and the lighting design industry with 'Light Up!'

In a new initiative, it has created a powerful forum for the hospitality industry with an exclusive partnership with the Hospitality Purchasing Managers Forum of India.



## WOODNEWS

WoodNews thanks the various companies that have submitted information. For any editorial submissions, please contact Mr. Dhananjay Sardeshpande, Chief Editor, at dhananjay@pdatrademedia.com. The information published in this, *Products and Processes, Notes and News* sections is as per the details furnished by the respective manufacturer/distributor. It does not reflect the views of WoodNews or of the management of PDA Trade Media.



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# Plantations supply 33% of all industrial roundwood

US and Brazil are top producers, India is 5th in world

A new study by the United Nations' Food and Agriculture Organisation (FAO) shows that forest plantations, which make up less than 7% of the forest area in the world, produce one-third of the world's industrial roundwood.

Roundwood is defined as logs, bolts or other sections of wood as cut from trees. Industrial roundwood (as opposed to fuelwood) is used in the manufacture of commercial products such as lumber, veneer, plywood and others.

In many developing countries expansion of wood-based manufacturing and export sectors has only been possible because of the raw material supply from plantations. The top five producers of industrial roundwood in forest plantations in 2012 were Brazil, the US, China, India and Chile.

The total production volume from plantations in 78 countries in 2012 is estimated at 562 million cubic metres, equivalent to one-third of the total global supply (1.7 billion m<sup>3</sup>) of industrial roundwood.

The global area of planted forests increased considerably between 1990 and 2010, from 178 million hectares to 264 million hectares, a difference that corresponds to 7% of total forest area. During 2005-2010, the area of planted forests expanded each year by about 5 million hectares on average. This expansion has been mainly achieved in Asian countries.

The contribution of planted forests to addressing the major socio-economic and environmental challenges of our time – poverty alleviation, food security, renewable energy, climate change, and biodiversity conservation – is widely acknowledged.

In many developing and developed countries, planted forests have

become a substantial component of the productive and protective forest resources, and provide a considerable share of the industrial roundwood production, says FAO.

## Plantation Species

In tropical and sub-tropical regions, the distinction between natural forests and planted forests or forest plantations is straightforward, as most plantations are based on single, non-native species stands, even age classes, short rotations and intensive management.

Consequently, the origin of industrial roundwood and the proportion originating from natural forests and plantations can, in many cases, be fairly easily determined as plantation species are often accounted for separately in the available country reports.

In some tropical countries (the Philippines, Sri Lanka, Thailand and Vietnam) temporary or permanent logging bans have been imposed in natural forests following periods of heavy deforestation and over-logging. These bans have often made forest plantations, besides wood imports, the only legal sources of industrial roundwood for local wood processing industries.

In temperate and boreal regions, native species may be grown in planted forests and plantations on long rotations and in mixed-species and mixed-age plantings. Natural forests and planted forests may often be so similar that they are indistinguishable.

Consequently, most national forestry agencies in temperate countries do not collect separate data on the industrial roundwood originating from natural or planted forests. In fact, most countries, with very few exceptions, find it difficult to identify



Pic: Pinepac, NZ

Testing density of poles.

the origin of the produced timber and to report accordingly.

Brazil and the US, the two largest producers, together produced about 43% of the global industrial roundwood from plantations (234 million m<sup>3</sup>) in 2012. The total industrial roundwood production reported from Brazil in 2012 for all types of forest was 146.8 million m<sup>3</sup>, making it the third-largest wood producer in the world.

China was found to be the third-largest producer of industrial roundwood from plantations in 2012. The Chinese State Forestry Administration estimates that by 2020 the domestic supply of commercial timber from plantations will increase to 80% of the national production due to large-scale plantation programmes that have been in place since the 1990s.

## India's Place

India was found to be the fourth-largest producer of industrial roundwood from plantations in 2012, with a total industrial roundwood production of 45 million m<sup>3</sup> from all types of forests. A significant share of this volume is presumed to originate from private plantations, farm forestry plantations and trees outside forests.

In New Zealand, Australia and South Africa, almost all industrial roundwood is extracted from forest plantations. Removals from natural forests in these countries were presumed negligible due to their official protection status.

The industrial roundwood production in natural forests was calculated by subtracting the production in planted forests from the total production. It amounts to 913 million m<sup>3</sup>, equivalent to 54% of the global production for that year.

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## Dieffenbacher eyes €500 million this fiscal



The Sveza Group has provided an additional contract from Russia for a particle board plant. The agreement was officially signed during a wood trade fair in the city of Ekaterinburg. The delivery of the plant, with an annual capacity of approximately 6,00,000 cubic metres, is scheduled for the second half of 2015.

Dieffenbacher, the German manufacturer of production systems for the world's wood panel industry, estimates a record volume of new orders totaling €500 million for the current fiscal year. The consolidated total turnover is expected to exceed €500 million for the first time in the company's history.

So far in the first half of 2014, five new orders for partial or complete plants with a continuous press have been completed. In addition, a number of contracts have been signed for which deposits are expected to be received in the coming weeks.

Despite the weakening economy and ever stronger local competition, Dieffenbacher has managed to secure two orders from China. It is supplying a THDF system to Hubei YiJiain, which includes a CPS 265-28 press that is expected to be delivered in April 2015. A second MDF plant with CPS 265-33

press is being supplied to a customer that is yet to be named, but is located in Xinjiang province. In addition, a contract has been signed for an OSB production line, which will take the number of Dieffenbacher continuous OSB systems in China up to five.

The scope of supply includes an energy system, refiner, dryer, gluing system, press and finishing line.

Russia remains the major market for Dieffenbacher, which has received an order from the Taleon Terra Group of St. Petersburg for an entire OSB system. The system output totals 6,00,000 cubic metres per year.

The scope of supply includes the debarking unit, a de-icing system from Dieffenbacher partner Holtec, strander, two drum dryers with a throughput of 35 BDT/hr, screening unit, forming line, a CPS 295-60 press and raw board handling, as well as tongue and groove systems with packaging lines.

Following the award of the Proteak contract for an MDF plant in November 2013, Dieffenbacher has won another order from Mexico's largest wood-based panel manufacturer in Latin America. Delivery will commence in February 2015. Thailand-based Green River has ordered another particle board plant from Dieffenbacher, in addition to the one already in operation since 2007. Delivery is expected to commence in May 2015.

The scope of supply includes a drum dryer, forming and press line and a twin diagonal saw. The forming station is supplied with a 4-head dispersion unit, which uses wind spreader heads with integrated roller screen. The benefits of deploying such technology include the considerably improved spreading tolerances with reduced raw material consumption and perfect surface quality, thanks to the reliable separation of impurities.

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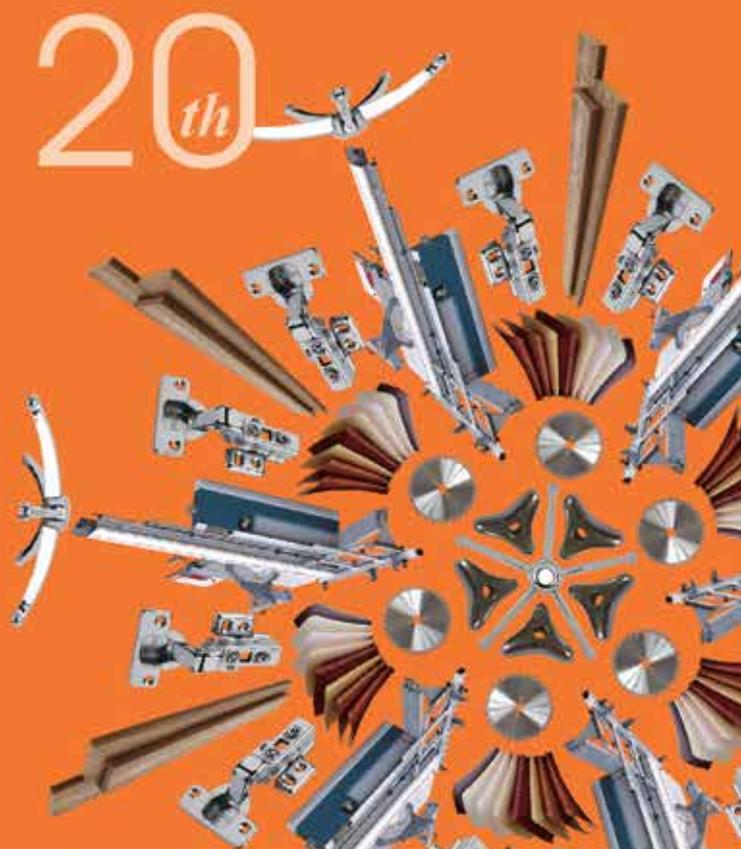


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## Highlights:

- ▶ Expanding the field of exhibits to decoration, engineering applications
- ▶ Expanding the field of visitors to the hotel project, decoration
- ▶ Upholstery furniture is moved in SWEECC
- ▶ Eight domestic and overseas associations has participated

Concurrently with:



FMC Premium 2014  
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Furniture China 2014  
Shanghai New Int'l Expo Center

## Global wood conference in Bangalore

The Institute of Wood Science and Technology (IWST), Bangalore, is organizing an international conference on 'Wood is Good: Current Trends and Future Prospects in Wood Utilization', from 21 to 23 November 2014.

It aims to provide a forum for academicians, researchers and wood industries across the globe to

present and discuss the most recent innovations, trends and challenges encountered in the field of wood science and technology.

The IWST works under the Indian Council of Forestry Research and Education, Ministry of Environment and Forests, to conduct research on wood science and caters to the research needs of the forestry sector at the regional level.

It is presently carrying out wide range of research activities in wood properties, wood processing and modification, wood protection and chemistry, wood-polymer composites, engineered wood and wood energy.

The themes for the international conference are: Wood Trade and

Policy (global and national demand and supply) and Wood Certification; Advances in Wood Science (processing, protection, modification, composites and engineered wood and nanotechnology applications).

There will also be papers on Reducing Carbon Footprint through life-cycle assessment of wood products, their recovery, reuse and recycling. Leitz Tooling Systems India Pvt. Ltd., Bangalore, is the organizing partner for this conference.

*For details, go to <http://woodisgood2014.iwst.icfre.gov.in/>, or contact Dr V. Ramakantha ([dir\\_iwst@icfre.org](mailto:dir_iwst@icfre.org)) or Dr K.K. Pandey ([kkpandey@icfre.org](mailto:kkpandey@icfre.org)).*

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## Acche din? Furniture factory for Rs. 19 lakh!

Pune-based Dreamworld Enterprises are focused on bringing "acche din" (good days) to the woodworking sector with an offer to set up furniture-making factories at just Rs. 19 lakh apiece.

The manufacturing machinery includes a panel saw, imported boring machine, post-forming machine, hot roller press, edge banding machine with trimmers, a spindle moulder and dust collector.

The entry-level factory setup is

aimed at small and medium-scale manufacturers and investors in Tier-III and Tier-IV towns across South and Western India. Already Dreamworld Enterprises has installed 14 such factories in the region over the past three months!

Along with the factory comes consultancy and prompt after sales service to Dreamworld's customers, who have discovered that a complete entry-level furniture factory is well within their reach, according

to Mr. Praveen Dhore, Director of Dreamworld Enterprises.

In light of its older customers planning investments in upgrading machinery and manufacturing technologies, Dreamworld Enterprises will shortly install its first newly developed vacuum press as an alternative for post-forming mainly in the kitchen area.

*For details email: [dreamworld1@gmail.com](mailto:dreamworld1@gmail.com) or [praveendhore@gmail.com](mailto:praveendhore@gmail.com)*

---

## Bosch opens 'experience centre' in Chennai

Bosch Power Tools recently launched its Bosch System Specialist (BSS) store in Chennai, the 54th in the country, to cater to the growing requirements of builders, interior designers and woodworking professionals in the burgeoning capital of Tamil Nadu.

Located on Mount Road, this newly-opened BSS store comprises of highly

qualified expert retailers who have specialized in the selling of Bosch power tools and add value in purchase decision of customers.

The concept of BSS has been an enormous success as it provides customer satisfaction by offering sales and service under a single roof. It acts as a one-stop shop for construction

solutions with its comprehensive range of power tools, accessories, total system solutions and expert counsel.

Consumers will be privy to a riveting experience as the store provides them with valuable demonstrations and a hands-on experience of tools, allowing them to make informed buying decisions.

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# Leitz introduces I-Door cutterhead



Leitz Tooling System has a pair of new products that made the first cut with judges of the IWF 2014 (Atlanta, US) Challengers Awards competition. Its I-Door (interior door) cutterhead and DFC dust extraction hood are semi-finalists in the biennial contest that recognizes industry innovation.

The Leitz I-Door cutterhead features a light-weight aluminium body and a combination of standard carbide and unique diamond inserts. Leitz says the tool's innovative design

maximizes tool life and exposed edge finish quality in the manufacture of wood core interior doors, typically constructed of hard, abrasive external surfaces such as hard fibre or fibreglass and relatively soft core material.

Tool life is maximized because replaceable diamond inserts at the top and bottom of the tool process the denser top and bottom surface laminates, while less expensive standard carbide inserts process the

softer core material.

Leitz says the combination tooling results in an "extremely smooth edge quality", eliminating the need for edge sanding. Leitz adds that because the diamond and carbide inserts are easily changed in-house, there is no need for multiple heads in rotation.

Downtime is also minimized and throughput is increased because the precise insert seating allows for fast and easy knife changes.

# Spotlight on digital printing for wood

Wood industry applications for digital printing and manufacturing technologies – including inkjet and 3D printing – were presented in four sessions at the International Woodworking Fair (IWF).

The largest trade for the secondary

wood manufacturing industries, IWF 2014 ran from August 20 to 23 at the Georgia World Congress Centre in Atlanta, USA

IWF 2014 included three presentations by Infotrends: 'Inkjet and Your Business: Primer for Your Inkjet Printing', 'Digitally Produced Surfaces: Real Life Examples,' and '3D Printing: Is It for Me'. 3D printers are being used by wood industry manufacturers to prototype machinery components, print out parts, or, using wood product-based 'ink', to make consumer goods.

Inkjet printing and other forms of

digital printing are being used to decorate panel for cabinetry, store fixtures and point-of-purchase displays produced by wood manufacturing companies. It is also being used to produce custom and short-run decor papers for laminate panels, and to decorate edge banding.

Enabled by a new generation of inkjet printing heads and by innovative integrators, new opportunities are now becoming commercially viable for the woodworking industry for décor applications, from one-of-a-kind pieces to high volume production.



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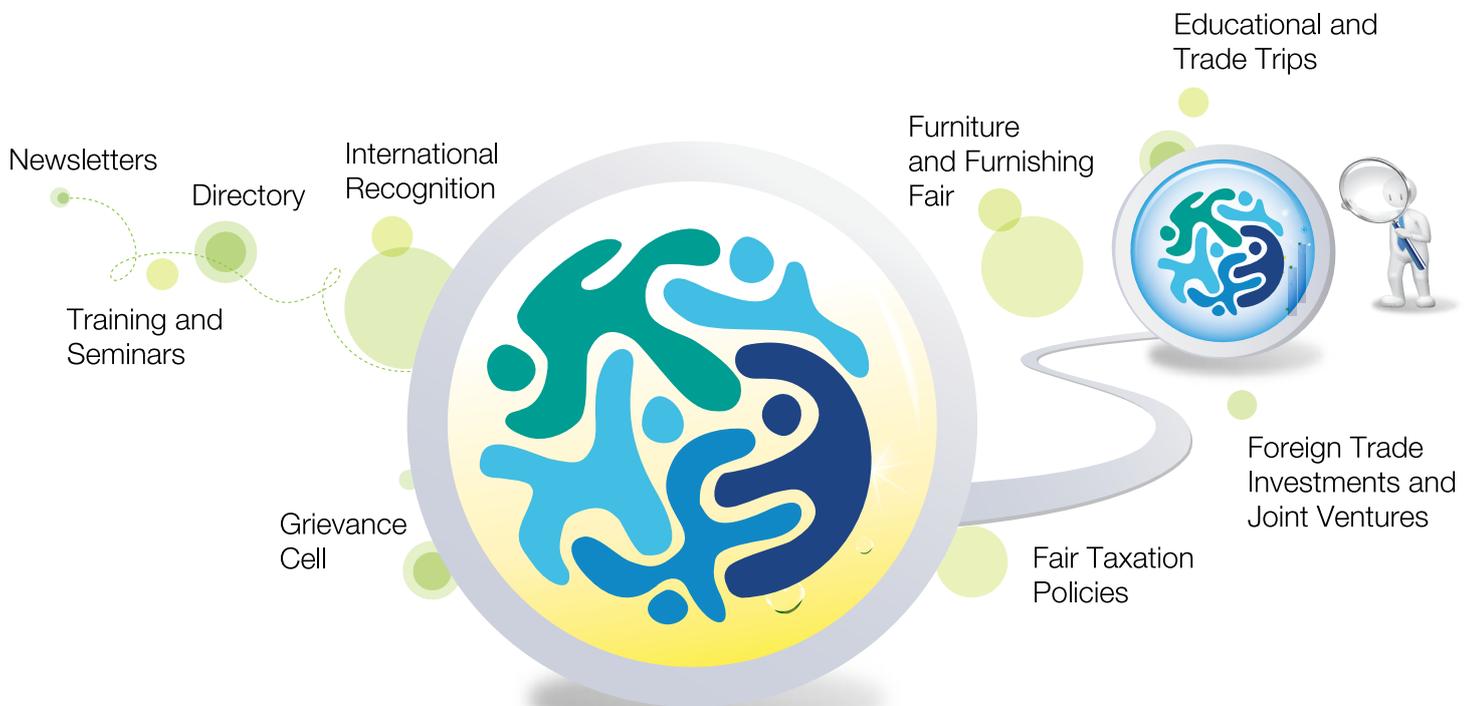


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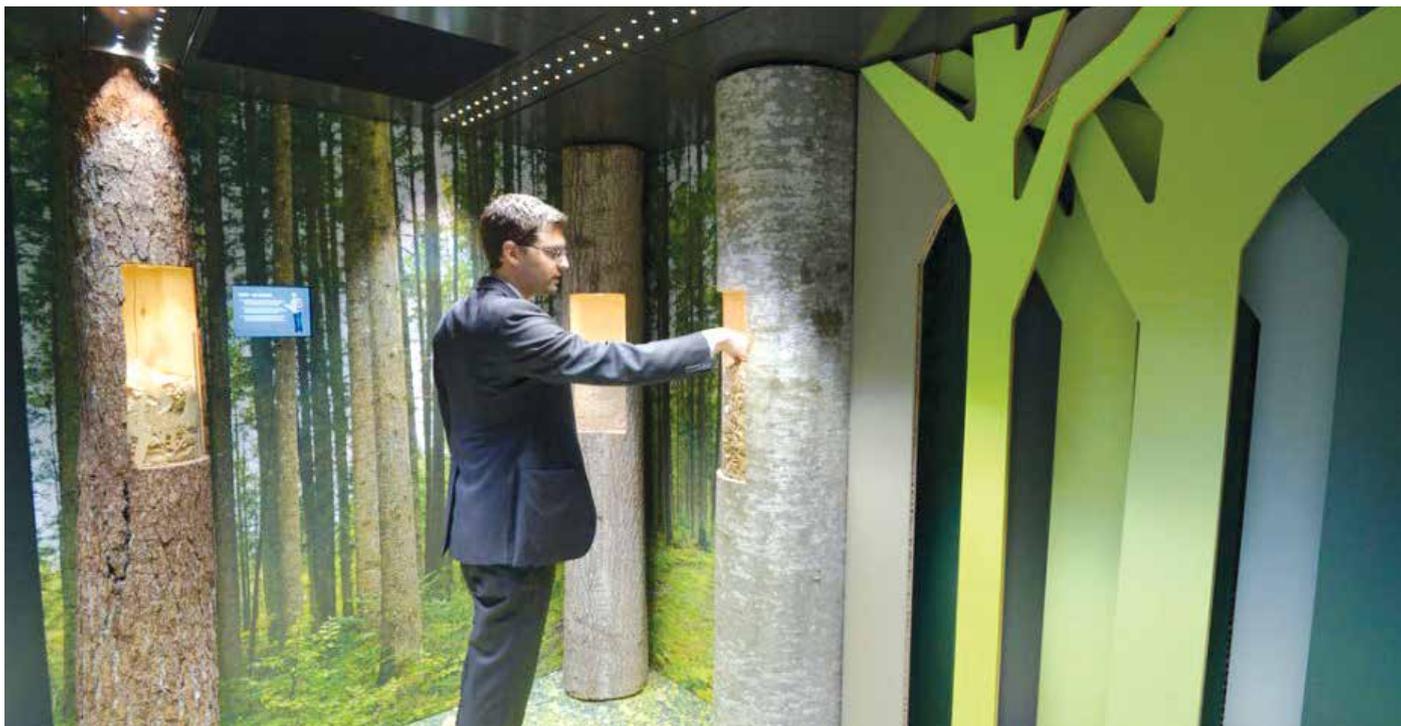
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## Ligna to host wood industry summit



Ligna, the leading trade fair for the forestry and wood industries, runs from 11 to 15 May, 2015, taking its commitment as the international shop window for the wood industry to the next level with an exciting new offering: a wood industry summit.

Organized by Deutsche Messe in partnership with the German Forestry Council (KWF), the all-new wood industry summit will comprise an exhibition area, a matchmaking platform and a forum, making it a powerful hub for international lead generation and dialogue. It will be staged on about 800 square metres of display area in Hall 13.

In the exhibition area, companies and institutions from the forestry technology, sawmill technology, wood panel products and veneer production, wood energy, solid wood working and pulp and paper

industries will showcase their latest technology offerings in the immediate vicinity of international group pavilions run by key players from carefully selected timber-rich target market regions, such as Russia, China and North and South America.

The matchmaking platform will feature institutions and delegations of high-ranking government and business representatives from Russia, China and North and South America, who will outline market access opportunities and regional wood-industry projects in their countries.

The platform is also an opportunity for companies from European countries, such as Finland, Sweden, Germany, Austria and Switzerland, to present their technologies to the participating wood-industry representatives and purchasing delegations from their international

target markets.

The third component of the summit is a special forum for key international representatives of industry, science and government. The aim of the forum is to present new solutions and the current state of the art in various technology areas, particularly harvesting technology, and to discuss current industry trends and issues.

The forum is also an opportunity to share detailed information on how to initiate business in key target markets and to find the best technology fit for specific countries. In 2015, the fair will once again highlight real solutions against the backdrop of current market trends and regulatory developments.



# Time to explore new business



## Show Issues

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WOODNEWS, published by the organisers of DELHIWOOD, will be dedicating three issues to support its exhibitors to reach potential buyers. These special issues are scheduled and designed to get maximum reach, before, during and after the show.

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## Henkel website a 'hit'

The latest 'IQ Digital Presence Ranking' prepared by the international communications agency, Investis, puts Henkel in the top 20. The study, published twice a year, assesses the Internet presence of companies in terms of user-friendliness and content. The Henkel website is currently ranked 13th

among the 331 companies analyzed.

Henkel's internet presence comes out particularly well in an industry-specific comparison with other consumer goods manufacturers: In the 'Personal and Household Goods' sector, the company holds the number one position among 50 contenders.

The 'Investis IQ Digital Presence Ranking' is one of the most extensive international benchmarking studies in its field. The agency applies some 200 criteria in assessing Internet presence quality, with the websites being evaluated on the basis of 12 different categories, including use of different multimedia resources, user navigation and site clarity, mobile accessibility, and page content related to topic variety.

## India eyes Latin American 'furniture corridor'

The Indo-Latin American 'furniture corridor' project was launched at a function in Bangalore on 11 August. Mr. S. Krishna Kumar, former Union minister, is head of the advisory board, while Saavin Design Innovations & Collaborative (SDIC) is the nodal agency for its implementation.

The proposed furniture corridor will be a global one-stop trade platform in conjunction with retail, integrating merchandise display, design, logistics, storage, information and finance.

The major strategy of the project will be "super value addition", timber

economy and livelihood in Surinam. It aims to be a hub of designing and manufacturing industrial furniture & interiors, building construction components, education and training of furniture enterprises.

SDIC is a collaborative of more than 1,000 woodworking and panel-processing and furniture manufacturing units, interior contractors and design firms, to provide opportunities to the business communities related to the wood furniture and allied industries.

SDIC aims to attract Indian youth to

be trained and employed in South American countries, where there is a requirement of 2,000 managers every year. Beginning in Surinam, the business can be developed in 33 other Latin American countries who export products to the US and European markets.

Since the proposed corridor is committed to providing opportunities to the business communities of both the countries, SDIC is inviting expression of interest from the industry to offer stake-holding in the project. For details, email: [sdic.blr@gmail.com](mailto:sdic.blr@gmail.com).

## Woodworking tech trade down

### Woodworking technologies: Export of Main competitors (2013, million Euro)

Exporter	Value	Var.%13/12
Germany	1,715.6	-3.1
Italy	1,111.3	-3.4
China	790.1	12.6
Taiwan	457.6	-0.2
Austria	355.8	-0.6
USA	283.7	-7.5

Source:

Acimall Studies Office, 2014. July

The figures of the global industry of woodworking technology are clear: all major international competitors in woodworking technology and machinery recorded a negative trend.

According to statistics processed by the studies office of Acimall (the Italian confederation of woodworking machinery manufacturers), exports decreased in Germany (-3.1% compared to 2012), though it was compensated by a strong domestic market. Italy also suffered (-3.1%), but was not mitigated by a stagnating domestic market.

Exports also decreased to the US (-7.5%), Austria (-0.6%) and Taiwan (-0.2%). Only China improved over 2012, with exports up 12.6% compared to 2012. It is clear that the US continues to be the biggest customer of international woodworking technology (Euro 836 million), followed by Russia (Euro 500 million). There were only 22 "virtuous"

countries: Turkey is firmly established with imports up by 14.8%, alongside Hungary and Algeria.

However, the analysis of figures and the results of surveys carried out among exhibitors and visitors confirm first impressions about the success of Xylexpo (13-17 May, 2014). The bi-annual trade fair at Milan Exhibition Center Fieramilano-Rho, covered 26,176 square metres of exhibition surface and hosted 440 exhibitors.

The exhibition area recorded 15,250 "unique visitors", which was 7.1% more than in the 2012 edition. Most visitors (22%) came from Europe, 5% from Asia and Oceania, 2% from the Americas and 1% from Africa. As many as 95.6% visitors voted to say they were most likely to visit Xylexpo in 2016.



# Maintenance of the J-4000R edge bander

The machine is an auto edge bander with radius trim for chamfering of panel corners, from the house of Jai. Before performing cleaning, maintenance, adjustments, fittings or removing any machine part, set the main switch to OFF position, disconnect the compressed air tube at the filter unit in-feed.

Using a power dust aspirator, clean tables and all cavities where there are dust and shavings residues; check that there are no blockages in the extractor hood; check the inside of the machine for dust or shavings, especially the end cutting, trimming and buffing units and the feed unit belt.



Clean any glue residues along the panel feed path, using a suitable non-hazardous detergent. Clean all moving parts, especially the ones exposed to resin and dust.

Scheduled maintenance is of utmost importance to obtain best performance as well as a safe operation of the machine. Accurate lubrication ensures long life as well as best performance. Grease the glue spreader roller unit after every 8 hours of operation. Do not use grease to lubricate the guides: use spray lubricant instead.

The machine is equipped with safety devices. Check the controls for emergency stops with a test once every fortnight. Periodically check that the guards are efficient and in good state.

Over time glue deteriorates and loses its adhesive properties; completely empty the glue tank and change the glue. Do not clean the glue tank with metal tools, since they will damage it. Use a wooden scraper instead.

### Trouble-shooting

If the machine does not start:

- Check the main switch & turn it ON.
- No electrical energy in one or more phase of the line: Check with a tester or multi-meter if there is voltage in the three phases R, Y & B.
- Emergency on: Switch off the emergency button by turning it.
- Fuses of auxiliary circuit to protect the transformer interrupted or fuse housing open: Close the fuse housing, if the machine does not start. Open the fuse housing, check the fuses, if necessary replace them.
- No compressed air or insufficient air: Connect the pneumatic system or check the compressed air feed line pressure for up to 6-7 kg/cm<sup>2</sup>.

### Panel does not slide:

- The height of the feed unit presser is not set according to the panel

thickness: Adjust the height of the feed unit presser according to the panel thickness, checking the perfect measurement of panel.

- Glue residue on in-feed fence, trimmer fence, presser rollers, base: Clean the glue.
- Conveyor switch turned to OFF: Turn it ON.

### Feed chain does not start:

- The motors of the units have not yet reached the right speed: Wait.
- Gluing temperature not reached: Wait.

### No glue on rear part of panel:

- Wrong panel insertion into the machine: Keep the panel in contact with the inlet fence.
- Glue not seen on the panel: Check the glue in the glue tank.

### Glue tank doesn't reach set temperature:

- One or more resistors burnt: Make sure that the electric input corresponds to the one applied.
- The electronic control does not operate; or the thermal probe does not operate: Check the





operation and if necessary, replace temperature control or heater or thermocouple wire.

**Glue quantity on panel inadequate:**

- Decrease or increase the glue flow according to requirement.
- Temperature value not proper: Check the glue melting temperature.

**Imperfect cut:**

- Glue residue on the tools or aligning units: Remove the glue residue and clean the area.
- Imperfect tool fixing or excessive

wear on the tool: Check the fixing or replace the tool.

- Panel not proper: Activate limit switch.

**Edge cut not regular:**

- In-feed shears knife: Check the sharpness of the cutter tool and replace it if necessary.
- Check the operation of the electric and pneumatic systems valves and replace any faulty parts.

**Incorrect transversal trimming:**

- Incorrect cutter adjustment: Adjust the position of the cutters.

**Splintered edging:**

- The tool cutting edges are worn: Check the sharpness of the tools. Sharpen the cutting edges or replace the tool.

**Incorrect buffing:**

- Insufficient or excessive intervention of the buffing wheels: Adjust the pressure of the buffing wheel.

# EVENTS CALENDAR

## FMC China

**Date:** 10-13 September, 2014  
**Venue:** World Expo , Exhibition & Convention Centre, Shanghai, China

The 20th China international furniture production, equipment and raw materials exhibition, a platform for showcasing production of furniture, decoration, engineering applications to provide the most sophisticated equipment, and high quality materials.  
Details: [www.fmcchina.com](http://www.fmcchina.com)

## Intermob-2014

**Date:** 27 Sept. to 1 Oct., 2014  
**Venue:** Tuyap, Istanbul, Turkey

The 17th international furniture side industry, accessories, forestry products and wood technology fair continues to be unique international trade platform of the forestry products and furniture industries in Eurasia. It also pursues the development of the industry and trade potential in the international market by the support of sector representatives, non-governmental organisations and media organizations.  
Details: [www.tuyap.com.tr](http://www.tuyap.com.tr)

## ASEANWOOD- WOODTECH

**Date:** 8-11 October, 2014  
**Venue:** Putra World Trade Centre, Kuala Lumpur, Malaysia

The 8th ASEAN International Woodworking Machinery, Timber Processing and Furniture Manufacturing Supplies Exhibition and Conference will take place in Kuala Lumpur, with the aim of assisting in the growth of the woodworking industry by providing a crucial platform for the movers and shakers of the industry to gather and network.  
Details: [www.tradelink.my/woodtech/](http://www.tradelink.my/woodtech/)

## INDEX-MUMBAI

**Date:** 9-12 October, 2014  
**Venue:** Bandra-Kurla Complex, Mumbai

Always a key feature of Index trade fairs is the large array of international products. The 26th edition of India's largest B2B interiors trade show will play proud host to companies from Italy, Spain, Portugal, Turkey, the United Kingdom, Malaysia, China, Taiwan and the United Arab Emirates.  
Details: [www.indexfairs.com](http://www.indexfairs.com)

## EXPOSICAM 2014

**Date:** 14-17 October, 2014  
**Venue:** Exhibition Centre Pordenone, Italy

ExpoSICAM is an international trade fair for components, technology products and accessories for the furniture industry. The event is greatly effective for all companies of accessories and components that operate in international markets furniture and furnishings.  
Details: [www.exposicam.it](http://www.exposicam.it)





# WHAT DO YOU THINK?

# WOODNEWS



George Fernandez, Director, Systems Engineering Consultants, Annanagar, Chennai (Tamil Nadu):

'Tulip bar turns a social hub' (*WoodNews*, July-Aug, 2014) is a commendable effort by AHEC to recycle tulip board into identical timber slats and presentation in parallel solid/transparent hollow sections to weave into exhibition space. India needs to look more carefully into design and recycling wood and infuse these ideas into woodworking, housing, exhibitions, museums, art galleries, malls and kitchens.

With reference to doors, the time has come for manufacturers in India to change over to 40/44-mm-thick doors. These tubular infill boards are eco-friendly, replace 80% timber, offer 50% weight reduction, good acoustics and fire protection.



Yogesh M. Patel, Patel & Company, Plastic Division, Old Victoria Road, Mumbai (Maharashtra):

*WoodNews* (July-Aug, 2014) special focus on doors and related articles was commendable. I would also like to see write-ups on bathroom/plastic doors and similar articles.



Mr. Kishor Dabhade, Thermwood, Nashik (Maharashtra)

Congratulations to *WoodNews* on bringing yet another successful edition (July-August 2014), focusing on doors this time. I am quite impressed by the contents, which impart a lot of knowledge on door manufacturing. All *WoodNews* readers would be immensely benefited! As always, I did not miss reading the Editorial.



R. Senthil Kumar, Proprietor, Sri Dhanalakshmi Saw Mill & Timber Mart, Mallikundam Road, Mecheri (Tamil Nadu):

*WoodNews* is a very useful magazine, to know about trade fairs and new machinery.

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